FutureTec

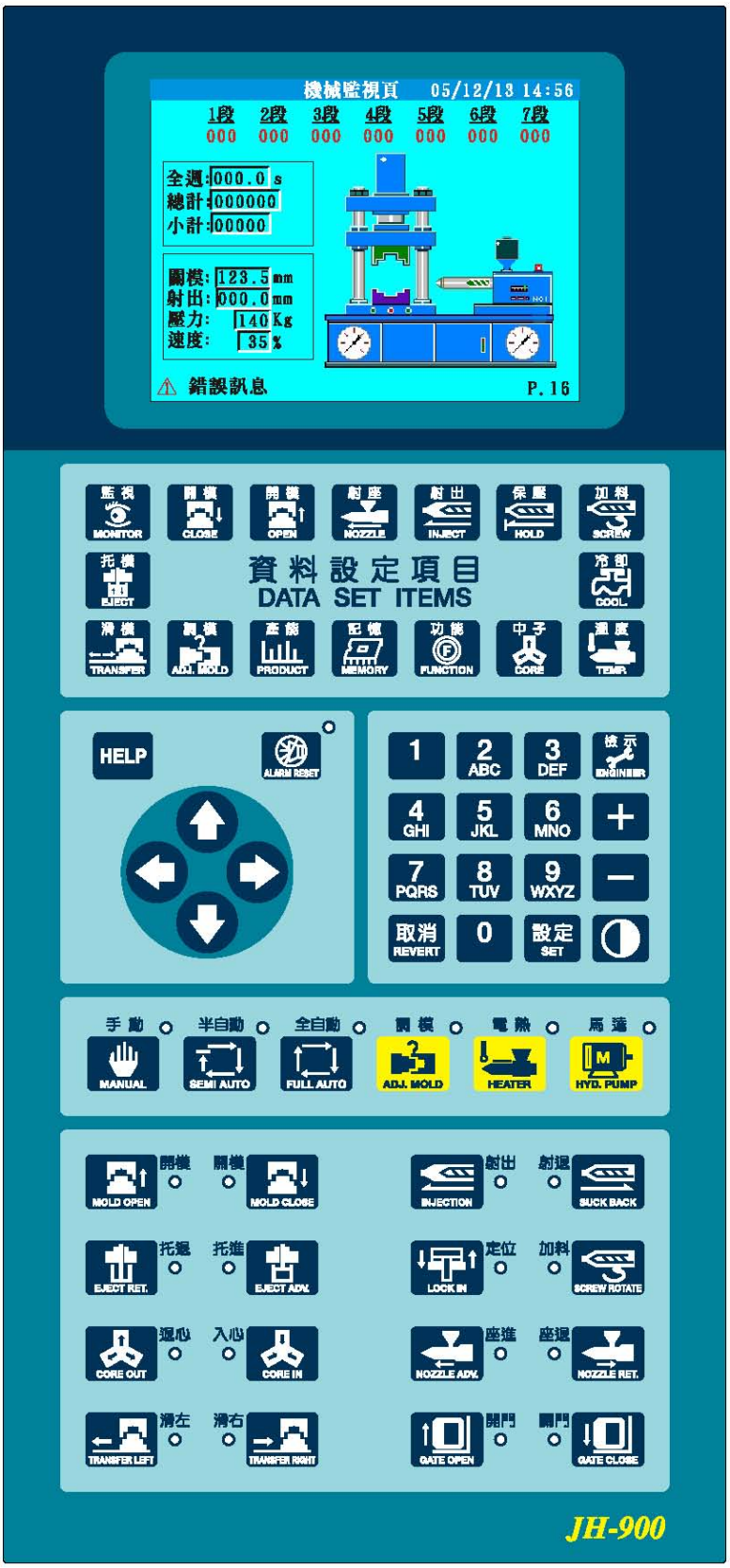
MICRO-CONTROL COMPUTER

Operating Instructions for JHV-15C Series

操控未來 ▶ 由我開始

FUTURE OF CONTROL BEGINS NOW

1031-AV 202.0x435.0xR1



Screen Area

Screen Selection Area

Direction Keypad

Number Keypad

Function Selection Area

Action Keypad

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0-1 Introduction for Data Set Items

: Press once to enter the machine dynamic screen.
: Press twice to enter the input monitoring screen.
: Press thrice to enter the output monitoring screen.
: Press four times to enter the expansion I/O monitoring screen.
: Press five times to enter the pointing monitoring screen.

: Press it into the mold close set screen.

: Press it into the mold open set screen.

: Press it into the nozzle set screen.

: Press once to enter the injection set screen.
: Press twice to enter the injection curve screen.

: Press it into the holding set screen.

: Press it into the screw set screen.

: Press it into the time / count set screen.

0-2 Introduction for Data Set Items

: Press once to enter the temperature set screen.
: Press twice to enter the preheating set screen.

: Press once to enter the core A set screen.
: Press twice to enter the core B set screen.

: Press once to enter the function set screen.
: Press twice to enter the time / count set screen.
: Press thrice to enter the data protection screen.

: Press it into the mold memory set screen.

: Press it into the QC monitoring set screen.
: Press twice to enter the product record screen.

: Press it into the mold-adjust set screen.

: Press it into the mold-transfer set screen.
: Press twice to enter the pointing set screen.

: Press it into the ejector set screen.
: Press twice to enter the moved / fixed mold air-blast set screen.

0-3 Description for Digit and Direction Key

The digital input key, English letter desired can be inputted for the second time.

e.g.: Press once “4”
Press once “g”
Press once “h”
Press once “i”

Press it into the engineer set screen. Note: the password should be entered.

Press it to add 1 or reduce 1 for number. If holding press, the number will be accumulative plus or minus.

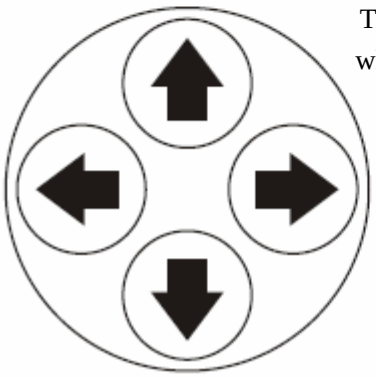
Digital backlight adjustment

When the number modified without confirming by SET button flashes, press "REVERT" to recover the previous setting value.

1. Press SET or “Shift” button for a new number inputted. The number flashing means that need to set.
2. The SET button can be used as on/off to switch the function.

It is Help key.

The button is used for alarm reset when alarm is produced, while the alarm records can be observed.

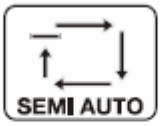


The key for cursor shift up, down, left or right

0-4 Description for Function Key

手 動 ○

LED on, in the manual status.

半自動 ○


LED on, in the semi-auto status.

全自動 ○

LED on, in the full-auto status.

調 模 ○

LED on, the mold adjust is in use.

電 熱 ○

LED on, the heater has been started.

馬 達 ○

LED on, the motor is running.

0-5 Description for Manual Operating Key

Action Key

開模

Mold Open Key: Press it to perform the mold open stroke.
Condition: The current position of moved mold shouldn't exceed the setting position value of mold-open-end.

關模

Mold Close Key: Press it to perform the mold close stroke.
Condition: The front and back safety door (19, 23), the robot end signal (18) and the ejector ret. end (10) should be ON, but the mold-close-end (07) and the proximity should be OFF.

射出

Injection Key: Press it to perform the injection 1.
Condition: The cylinder temperature should be up to the set value and the setting button of heater should be ON.

射退

Suck-Back Key: Press it to perform the suck-back stroke.
Condition: The cylinder temperature should reach the set value.

托退

Eject Ret. Key: Press it to perform the ejector backward stroke.
Condition: The proximity (10) of ejector ret. end should be OFF.

托進

Eject Adv. Key: Press it to perform the ejector forward stroke; the ejector action will go on if holding press.
Condition: Start from the mold-open-end position and the proximity of ejector adv. end should be OFF.

座進

Nozzle Adv. Key: Press it to perform the unit forward stroke; the slow nozzle adv. will be acted if meeting the proximity of nozzle adv. end.
Condition: The mold close is finished before the unit forward, and the mold-close-end (7) should be ON.

座退

Nozzle Ret. Key: Press it to perform the unit backward stroke.

退心

Core Out Key: Press it to perform the core A out stroke.
Condition: Core A used should be selected, and the action mode and position should be set.

0-5 Description for Manual Operating Key

Action Key

入心

Core In Key: Press it to perform the core A in stroke.
Condition: Core A used should be selected, and the action mode and position should be set.

加料

Screw Key: Press it to perform the screw stroke.
Condition: The cylinder temperature should reach the set value, the screw time should be set and positioning.

滑右

Transfer Right Key: Press it, the mould will transfer right.
Condition: The eject ret. end should be ON, and the mold-open-end should be reached.

滑左

Transfer Left Key: Press it, the mould will transfer left.
Condition: The eject ret. end should be ON, and the mold-open-end should be reached.

定位

Lock-In Key: The discal machine is started to use; press the button, the positioning dowel will eject up.
Condition: The transfer left/right end should be ON.

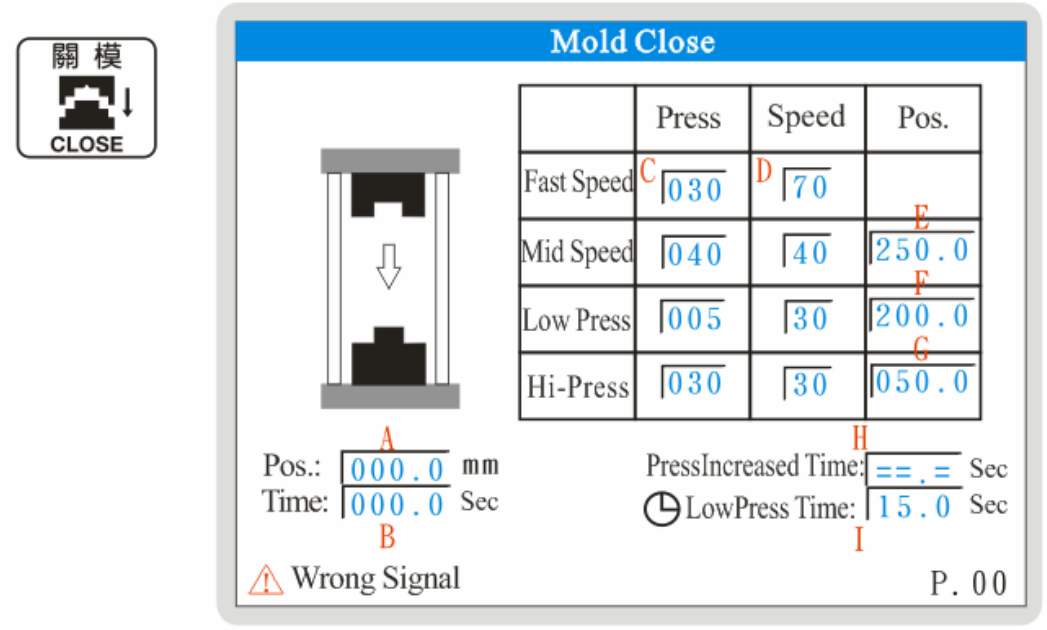
開門

Gate Open Key: Press it to perform the air-door open stroke.
Condition: Set the air-door function to ON.

關門

Gate Close Key: Press it to perform the air-door close stroke.
Condition: Set the air-door function to ON.

1. Mold Close Screen

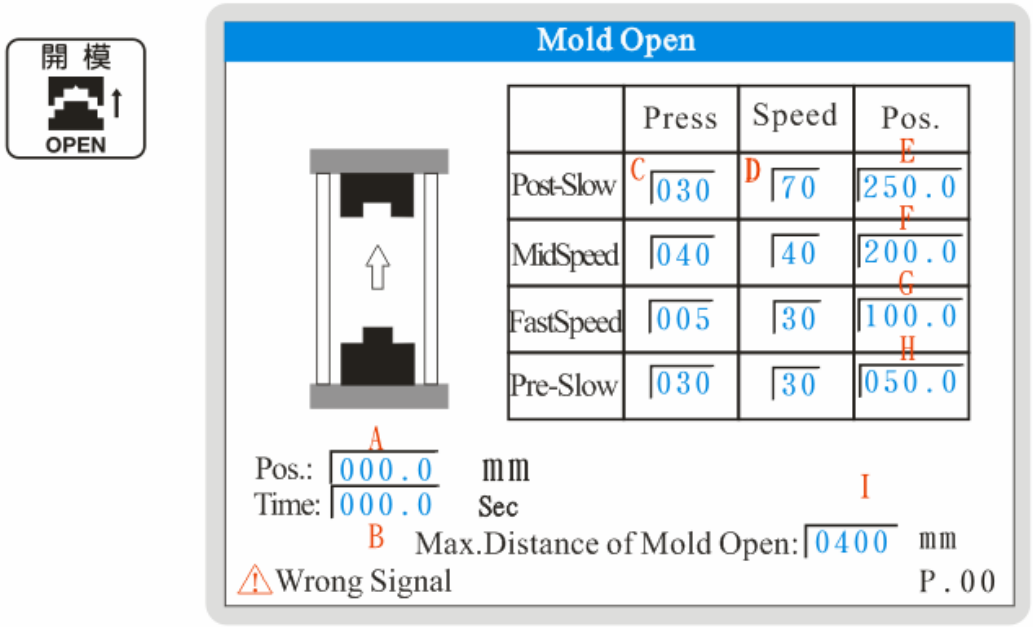


Code	Status	Scope	Description
A	Actual Value	0-999.9 mm	Display the current position for the displacement transducer of moved mold.
B	Actual Value	0-99.9 sec	Display time for the action route of mold close.
C	Set Value	0-140 kg	The set value of pressure
D	Set Value	0-99%	The set value of speed
E	Set Value	0-999.9 mm	The position of fast speed switching to mid speed when closing mold.
F	Set Value	0-999.9 mm	The position of mid speed turning into low pressure when closing mold.
G	Set Value	0-999.9 mm	The position of low pressure changeover hi-pressure in closing mold, namely, the position of mold-close-end.
H	Set Value	0-99.9 sec	The pressure increased time is going on after the hi-pressure reaches, then close the hi-pressure.
I	Set Value	0-99.9 sec	Mold close reaches the low pressure position (F) and start to time, and the hi-pressure position (G) should be reached in the low pressure time, or else, “low pressure time is over” is alarmed and mold open is up to the mold-open-end.

**** Notes ****

1. The distance of mold close should be set from large to small, then E>F>G action can run smoothly.
2. The low pressure of mold close shouldn’t be set beyond 10KG, and the low-pressure position exceeds the hi-pressure one at least 50mm.
3. To set the high-pressure position, firstly set it to “0” after the mold adjust, then according to the mold close stroke until the mold is so close that mold close could not continue. Here the position of moved mold is the actual hi-pressure position. Thus, adding 0.5mm on it to input into the hi-pressure position.

2. Mold Open Screen

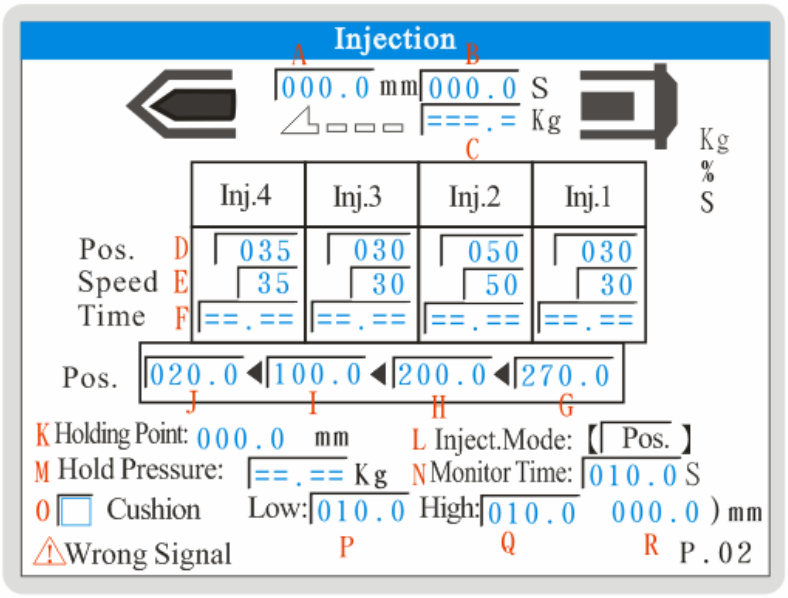


Code	Status	Scope	Description
A	Actual Value	0-999.9 mm	Display the current position for the displacement transducer of moved mold.
B	Actual Value	0-99.9 sec	Display time for the action route of mold open.
C	Set Value	0-140 kg	The set value of pressure
D	Set Value	0-99%	The set value of speed
E	Set Value	0-999.9 mm	It is the position of mold-open-end that should be below the maximum open-distance (L). Otherwise, it can't be inputted.
F	Set Value	0-999.9 mm	The position of mid speed switching to back slow when opening mold.
G	Set Value	0-999.9 mm	The position of fast speed turning into mid speed in the mold open.
H	Set Value	0-999.9 mm	The pressure increased time is going on after the hi-pressure reaches, then close the hi-pressure.
I	Show Value	0-999.9 mm	It is the maximum open-distance that is the longest mold-open stroke, which is set by machinist before leaving factory and can be changed in the engineer screen. The mold-open-end (E) should be set below this value.

**** Precautions ****

1. Set the distance of mold open from small to large, E>F>G>H action then can run smoothly.

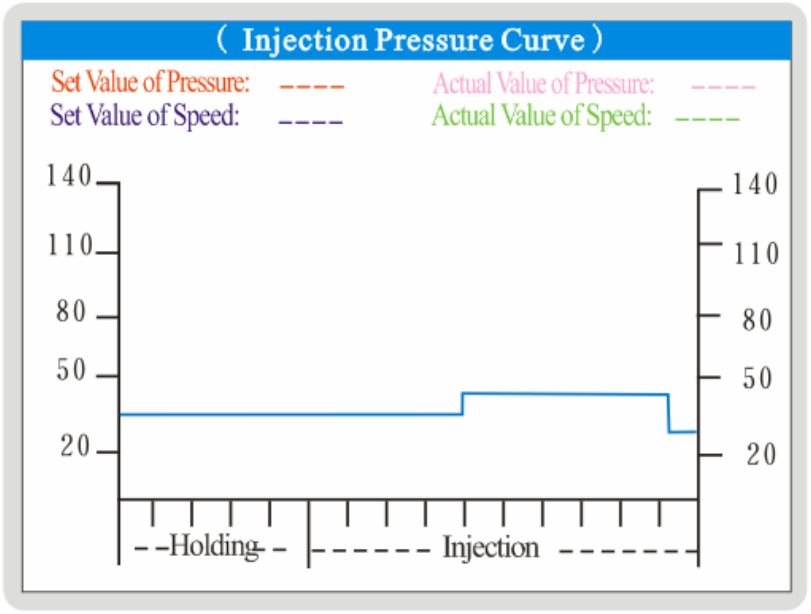
3. Injection Screen　　3-1. Injection Set Page



Code	Status	Scope	Description
A	Actual Value	0-999.9 mm	Display the present position for the displacement transducer of screw pole.
B	Actual Value	0-999.9 s	Display time for the action route of screw pole.
C	Actual Value	0-140 kg	Display the pressure sensor.
D	Set Value	0-140 kg	The set value of pressure.
E	Set Value	0-99%	The set value of speed.
F	Set Value	0-99.99 s	The injection action will be performed according to the set time if Time is selected for the injection mode.
G	Set Value	0-999.9 mm	The position of injection 1 end changeover injection 2 start. The injection 1 will not act if the value is set to “0”.
H	Set Value	0-999.9 mm	The position of injection 2 end changeover injection 3 start. The injection 1 will not act if the value is set to “0”.
I	Set Value	0-999.9 mm	The position of injection 3 end changeover injection 4 start. The injection 1 will not act if the value is set to “0”.
J	Set Value	0-999.9 mm	The position of injection 4 end changeover injection holding start. The injection 1 will not act if the value is set to “0”.
K	Actual Value	0-999.9 mm	Display the position of holding point.
L	Set Value	Time, Position	Press SET button to change the options (Position and Time is optional).
M	Set Value	0-140 kg	The set value 3 is the reference point when judging the holding point with the pressure sensor.
N	Set Value	0-99.99 s	It is the monitoring time from injection 1 to injection 4, which should be set beyond the time of injection route. Jump to the holding stroke when the injection time is over.
O	Set Value	☐ , ☑	Press SET button to change the options: R-P position is reference point of injection spillage. Regard K as R before selecting: R+Q position is reference point of injection shortage.

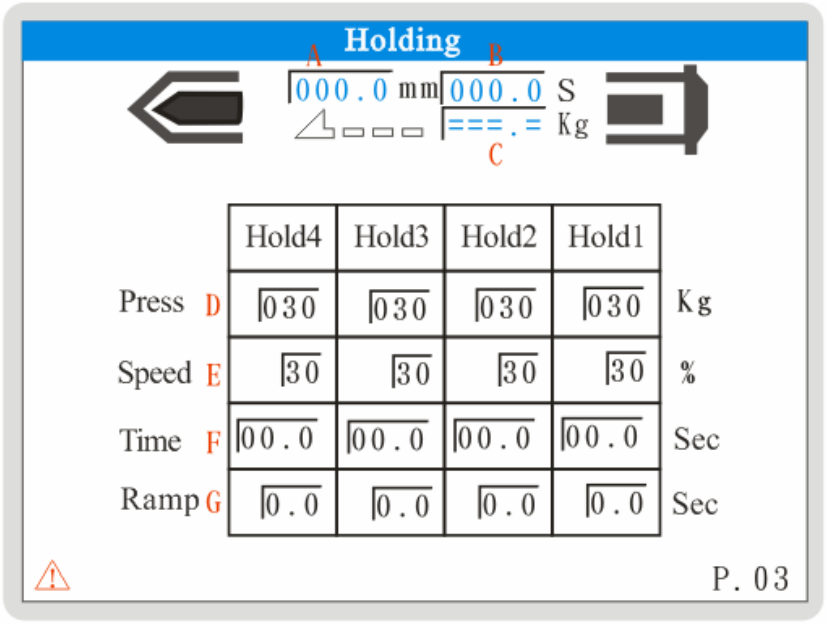
3-2. Injection / Pressure Curve Page

Press twice



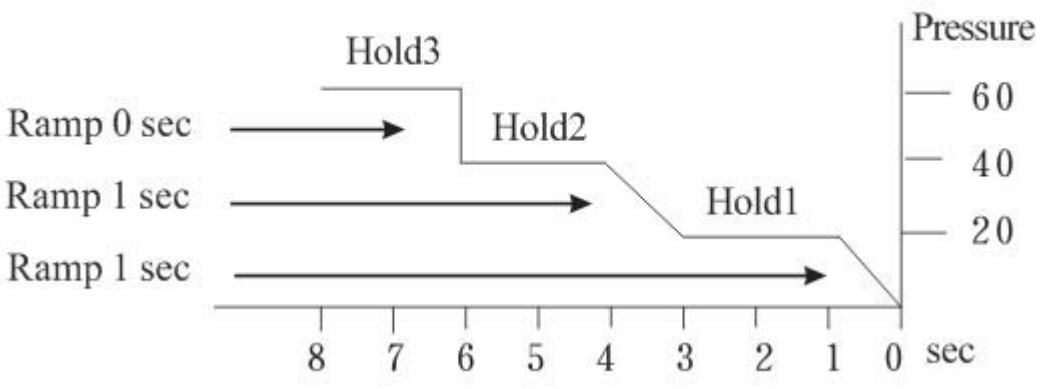
※ Provide shaping reference and display actual pressure and flow curve according to the set pressure value and flow value shown by the curve in the injection curve screen.

4. Holding Screen

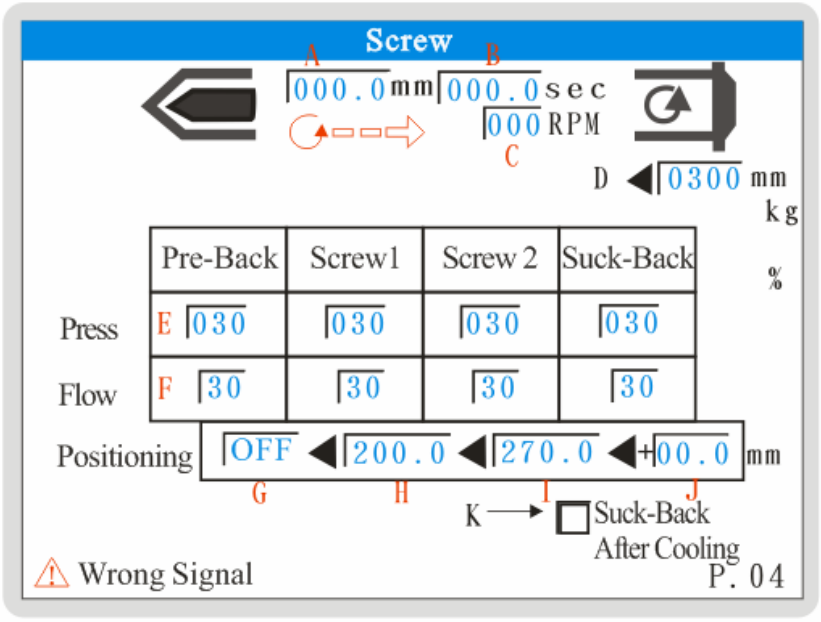


Code	Status	Scope	Description
A	Actual Value	0-999.9 mm	Display present position for the displacement transducer of screw pole.
B	Actual Value	0-999.9 s	Display time for the action route of screw pole.
C	Set Value	0-140 kg	Display the pressure sensor.
D	Set Value	0-140 kg	The set value of pressure.
E	Set Value	0-99%	The set value of speed.
F	Set Value	0-99.99 s	Holding is performed by the set time. Don't act if the value is set to "0".
G	Set Value	0-9.9 s	If it isn't "0", the pressure of this section will act by the up ramp firstly, then perform the pressure speed of F set time.

Ramp Diagram of Injection Holding:

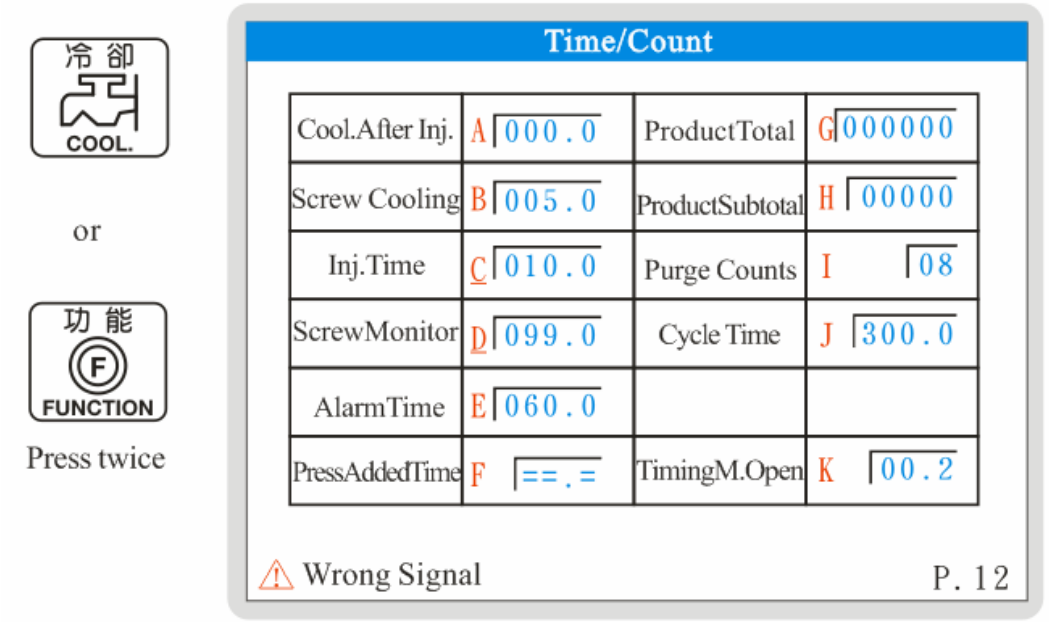


5. Screw Set Screen



Code	Status	Scope	Description
A	Actual Value	0-999.9 mm	Display present position for the displacement transducer of screw pole.
B	Actual Value	0-999.9 s	Display time for the action route of screw pole.
C	Actual Value	0-99.9 RPM	Display the screw RPM, which can only be shown after the screw rotating sensor is set up.
D	Set Value	0-999.9 mm	The maximum of screw distance that show the longest screw route of machine, which is set by machinist before leaving factory and can be changed in the engineer screen. The screw end should be below this value.
E	Set Value	0-140 kg	The set value of pressure.
F	Set Value	0-99%	The set value of speed.
G	Set Value	0-99.9 mm	At first, perform the front suck-back position after injection. Generally, please set the position H to 0 if no use.
H	Set Value	0-999.9 mm	The position of screw 1 end changeover screw 2 start. Set the value to 0 if the section 1 is only used for the screw.
I	Set Value	0-999.9 mm	The position of screw 2 end changeover post suck-back start.
J	Set Value	0-999.9 mm	Position of suck-back distance again. The position of screw end is I + J.
K	Show Value	☐ , ☑	Suck-back after cooling when using. Cooling after suck-back if no using.

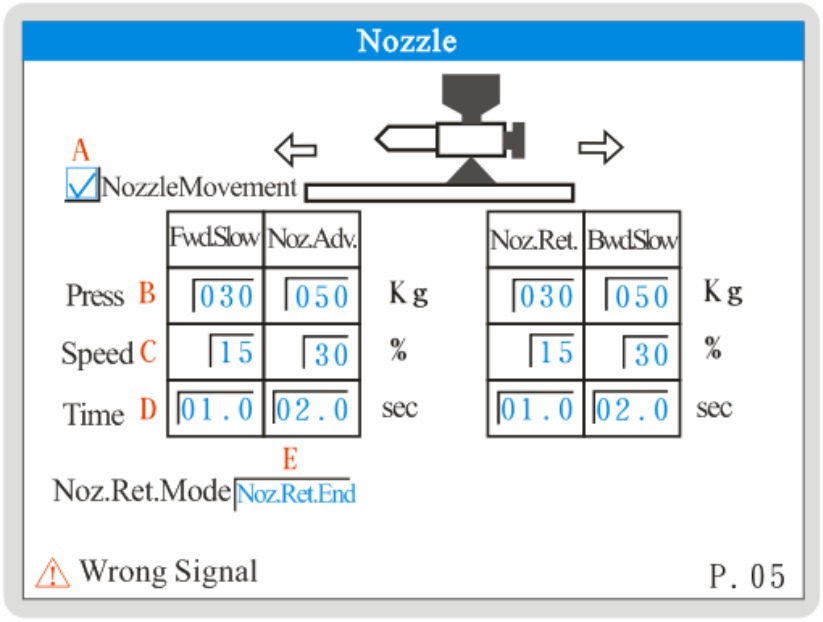
6. Cooling Screen　　Time / Count Set Page



Code	Status	Scope	Description
A	Set Value	0-999.9 sec	Perform the set cooling time after injection, then suck-back and screw.
B	Set Value	0-999.9 sec	Perform the set cooling time after screw.
C	Set Value	0-999.9 sec	The same as the monitoring time of injection screen. Perform holding once the accumulative injection time is equal to injection time or monitoring time.
D	Set Value	0-999.9 sec	Display no stuff while the accumulative screw time is beyond this set value.
E	Set Value	0-999.9 sec	The accumulative alarm time will appear when the machine fails.
F	Set Value	0-99.9 sec	Time of increasing pressure will continue to perform after the hi-pressure position reaches, then close the hi-pressure.
G	Set Value	0-999999 mold	The alarm “Production Doesn’t Go On” will appear while the set counts of total production molds are produced.
H	Set Value	0-99999 mold	The alarm “Continue To Produce Again” will appear while reaching the subtotal counts of production molds are produced.
I	Set Value	0-99 counts	Set the times of screw.
J	Set Value	0-999.9 sec	The alarm occurs if accumulative time of cycle monitoring is beyond this value.
K	Set Value	0-9.9 sec	Closing mold while delaying this set time between after the previous 1 mold and before the next one.

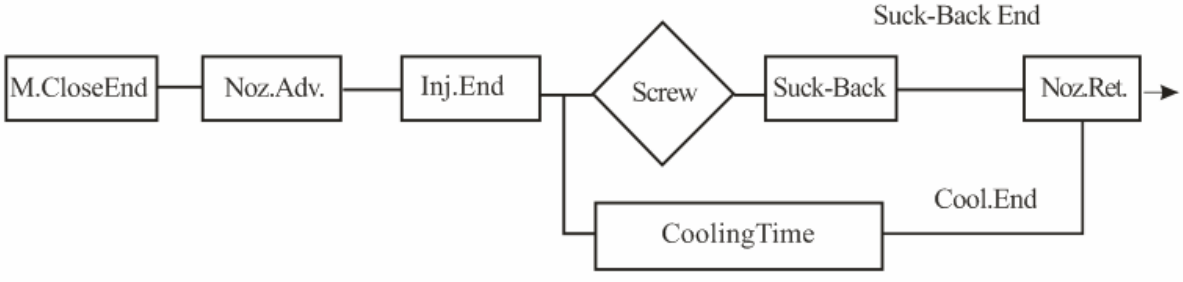
7. Nozzle

7-1. Nozzle Movement Set Page

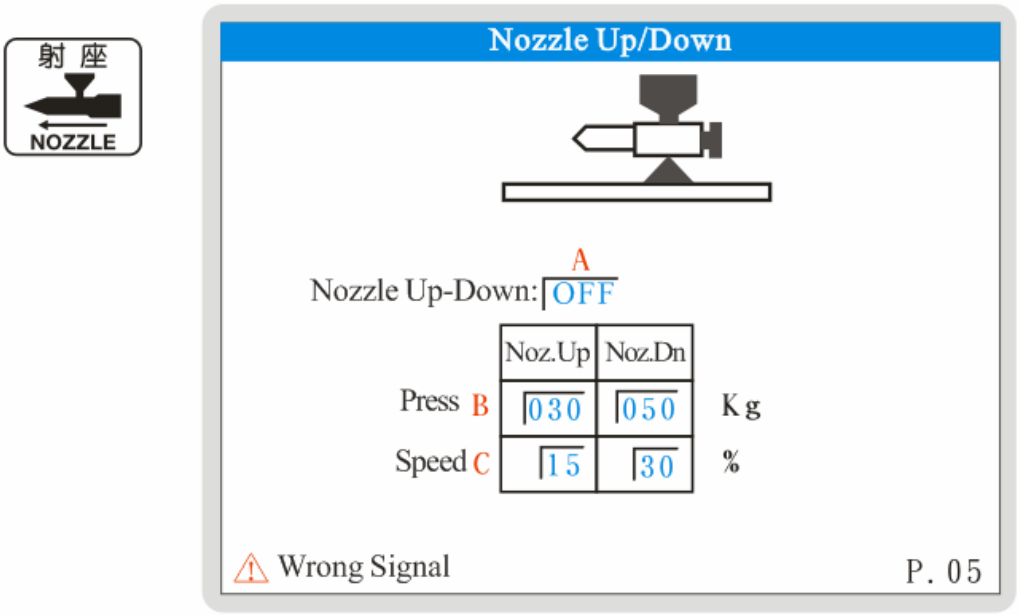


Code	Status	Scope	Description
A	Set Value	☐ , ☑	Press SET button to switch over. Use: perform the nozzle ret. after injection and suck-back are completed, then perform the nozzle adv. waiting for the next mold close finished.
B	Set Value	0-140 kg	The set value of pressure.
C	Set Value	0-99%	The set value of speed.
D	Set Value	0-99.9 sec	Adjust nozzle adv./ret. by time for the nozzle route while using the nozzle movement.
E	Set Value	Cooling End	Perform nozzle ret. stroke after timing screw-cooling is finished while the nozzle movement.
		Suck-Back End	Perform nozzle ret. stroke after screw suck-back is finished but the cooling time reaching isn't waited for while the nozzle movement.

The flow chart for the nozzle movement used:

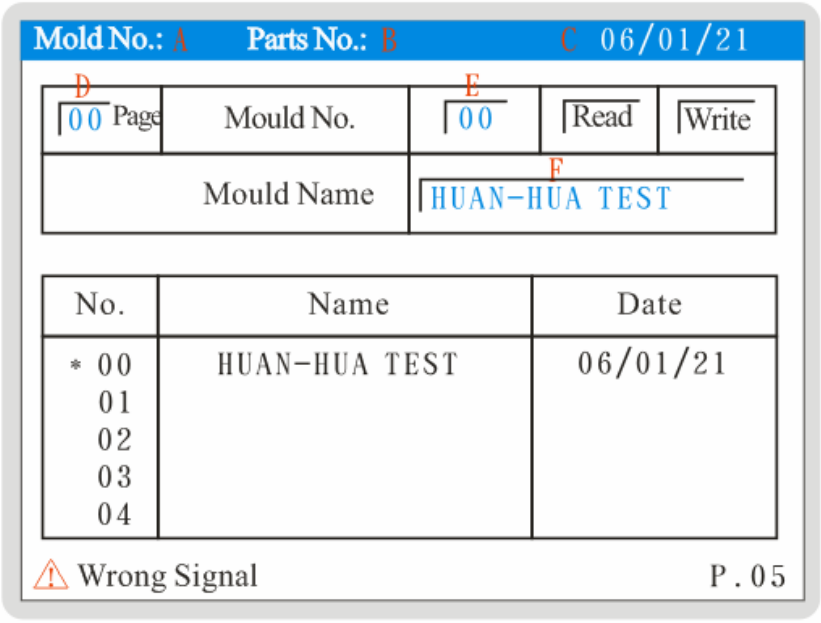


7-2. Nozzle Up/Down Set Page



Code	Status	Scope	Description
A	Set Value	ON/OFF	Press SET button to switch over. ON: In Manual Status: press Nozzle Up button to perform the nozzle up; press Nozzle Down button to perform the nozzle down.
B	Set Value	0-140 kg	The set value of pressure.
C	Set Value	0-99%	The set value of speed.

8. Memory Screen



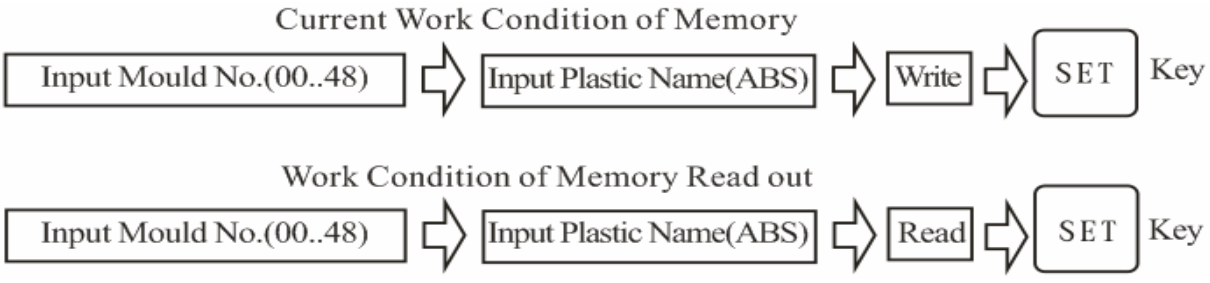
*** Note:** 0 to 48 sets are savable inner of this computer, and with additionally optional memory card is used for 50 to 99 sets.

Code	Status	Scope	Description
A	Actual Value	0-99	Display the serial number of mould used at present.
B	Actual Value	0-9, A-Z	Display the name of mould used at present. Please refer to appendix 1.4 for English input.
C	Actual Value	Date	Display the mold number used at present and the date written of the time.
D	Set Value	0-19 pages	Display the memory screen that includes 19 pages, which to provide the contents switched by pressing plus/minus button for user.
E	Set Value	0-99	Set the serial number of mould desired to write in or read out.
F	Set Value	0-9, A-Z	Set the mould name desired to save. Keep in mind! Firstly input the serial number of mould.

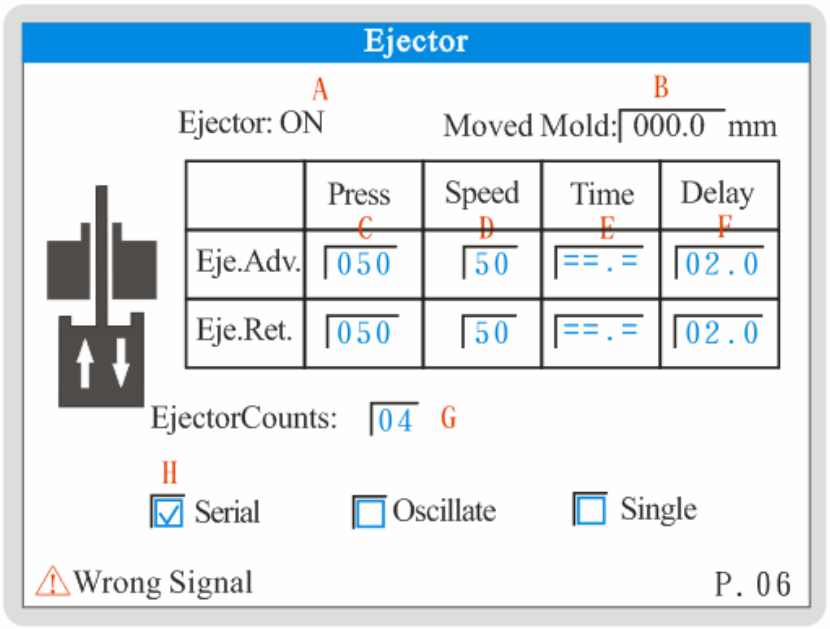
Save the current data into the memory------flow:

1. First confirm the current action parameter as saving value desired.
2. Observe if there is blank area left in the table of contents. ***49 sets are not savable, but the memory card is needed for 50 to 99 sets. ***
3. If there is not blank area, the memory number isn't selected for the cover mode, and the mould number must be first confirmed.
4. After input mould number, the mould name can be edited; If haven't the names, can also written in or read out.

Flow:

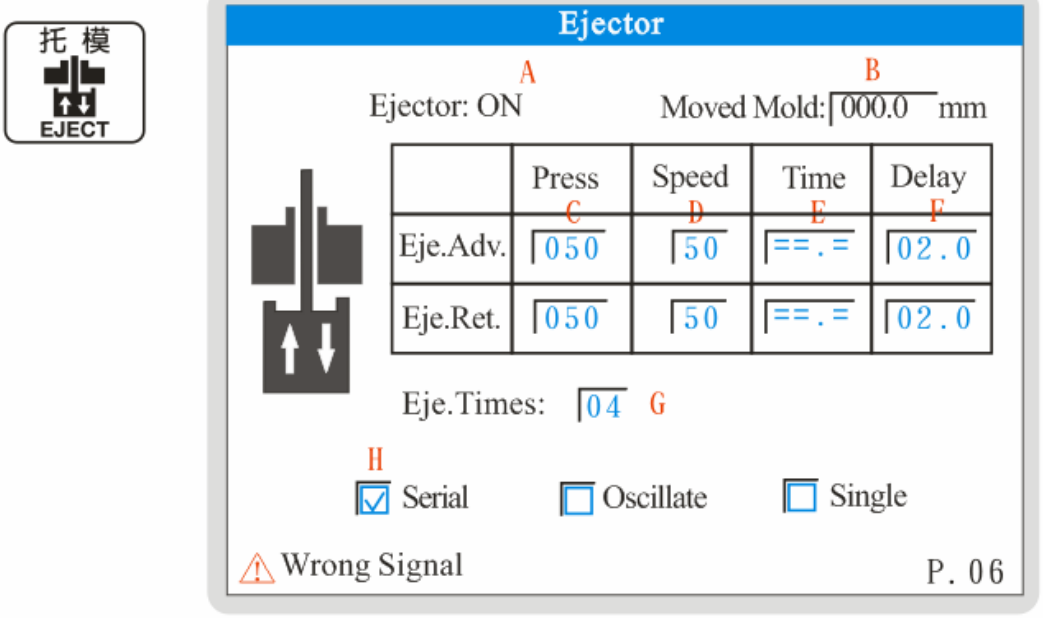


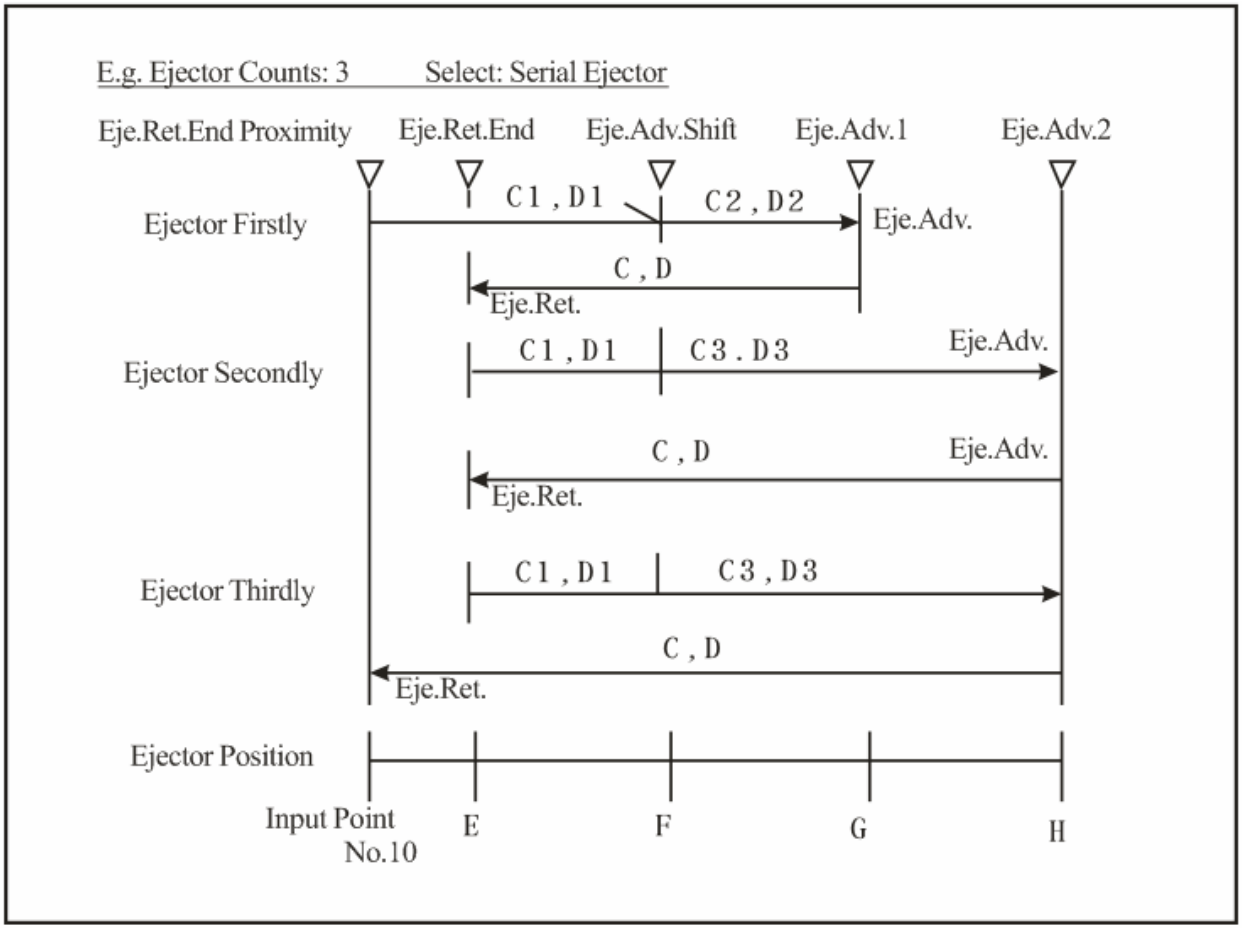
9. Ejector Screen



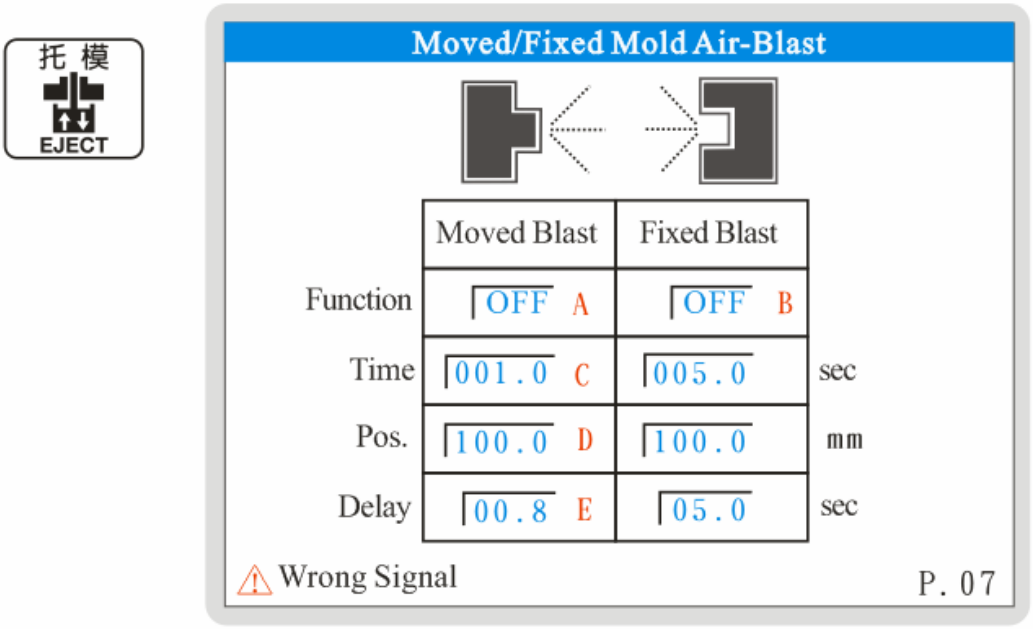
Code	Status	Scope	Description
A	Set Value	ON/OFF	Press SET button to switch over.
B	Actual Value	0-999.9 mm	Display the current position for the displacement transducer of moved mold.
C	Set Value	0-140 kg	The pressure value
D	Set Value	0-99%	The flow value or speed
E	Set Value	0-99.9 sec	Time of ejector forward/backward
F	Set Value	0-99.9 sec	Set the delay time before the ejector forward/backward acts.
G	Set Value	0-99 counts	Count the ejector times, serial ejector and oscillating ejector according to this set value.
H	Set Value	ON/OFF	Press SET button to switch over.
Serial Ejector		Perform ejector forward and backward action according to the set ejector times.	
Oscillating Ejector		Perform the fast oscillation of ejector forward and backward according to the set ejector times.	
Single Ejector		Perform ejector forward after the mold-open-end and don't perform ejector backward at once when the adv. end is reached; but do it before the next mold close.	

9-1. Description for Ejector Stroke



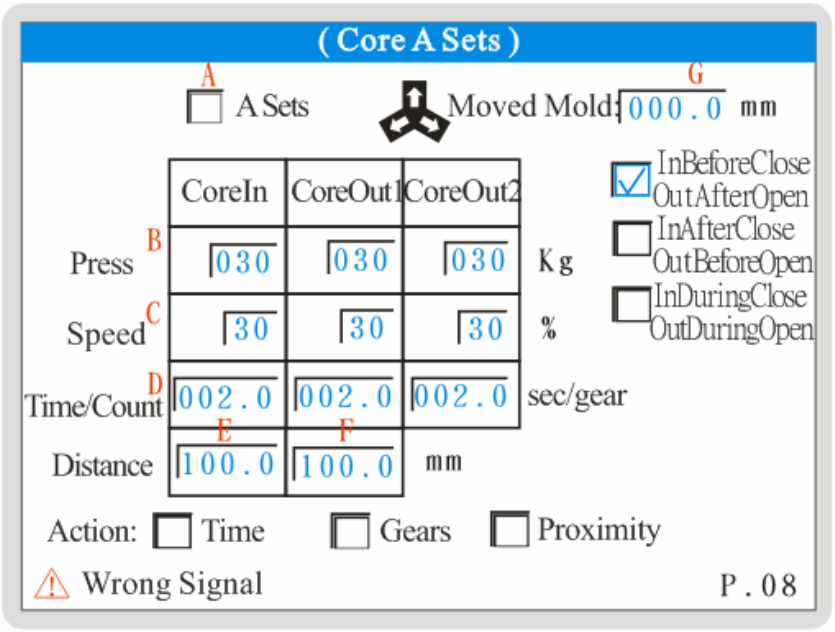


9-2. Moved/Fixed Mold Air-Blast Set Page



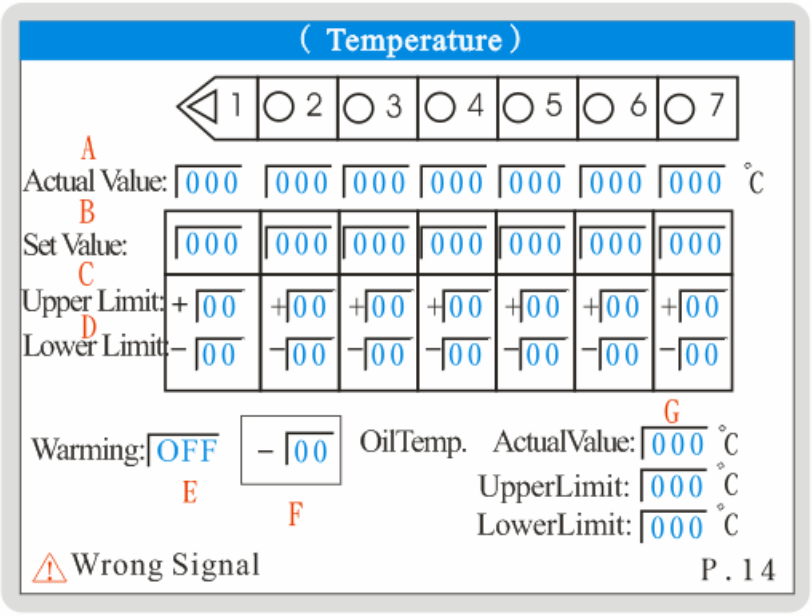
Code	Status	Scope	Description
A	Set Value	ON/OFF	Press SET button to switch over.
B	Actual Value	ON/OFF	Press SET button to switch over.
C	Set Value	0-999.9 sec	Set the action time performed.
D	Set Value	0-999.9 mm	Set where position of the moved mold to perform the air-blast action.
E	Set Value	0-99.9 sec	Set the time of air-blast action performed by the delay.

10. Core Set



Code	Status	Scope	Description
A	Set Value	ON/OFF	ON: means that the core function is set to use.
B	Actual Value	0-140 kg	Pressure value.
C	Set Value	0-99%	Flow value, speed.
D	Set Value	Sec, Gears	Time is selected for core mode, then E is second; if Gear selected, E is gears unit.
E	Set Value	0-999.9 mm	Control by distance; Set this position of moved mold as that of core in action.
F	Set Value	0-999.9 mm	Control by distance; Set this position of moved mold as that of core out action.
G	Actual Value	0-999.9 mm	Display the current position for displacement transducer of moved mold.
Core Sensor Mode		☑ Time	Show the core forward/backward stroke, and by the time parameter.
		☐ Gears	Generally is unscrew used, the count photocell is necessary, and by the gears parameter.
		☐ Proximity	The mould or oil cylinder should be with additional proximity, and by the proximity switch parameter.
☑ In before close, Out after open		Core In ⇨ Mold Close ⇨ Mold Close End Mold Open ⇨ Mold Open End ⇨ Core Out	
☐ In after close, Out before open		Mold Close ⇨ Mold Close End ⇨ Core In Core Out ⇨ Mold Open ⇨ Mold Open End	
☐ In during close, Out during open		Mold Close ⇨ Core In ⇨ Mold Close End Mold Open ⇨ Core Out ⇨ Mold Open End	

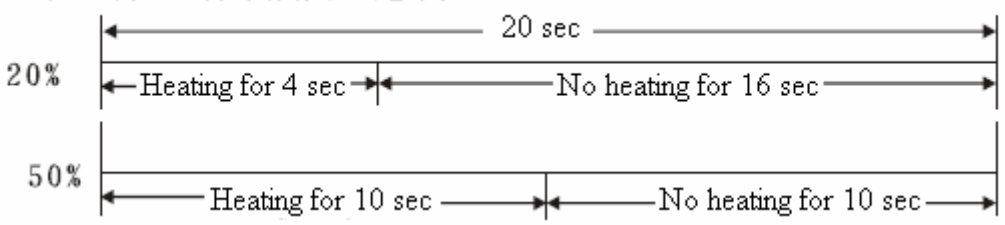
11. Temperature Screen　　11-1. Temperature Set Page



Code	Status	Scope	Description
A	Actual Value	0-399 C	Display current temperature of cylinder.
B	Set Value	0-399 C	The temperature needed for cylinder.
C	Set Value	0-99 C	Degrees beyond the set value are allowed.
D	Set Value	0-99 C	Degrees below the set value are prohibited.
E	Set Value	ON/OFF	If ON, control temperature according to the setting of F value minus that of B value. Normally, OFF.
G	Set Value	0-99 C	Display present temperature of oil.
H	Set Value	0-99 C	The temperature of oil, if which is rising to exceed, alarm will appear.
I	Set Value	0-99 C	The temperature of oil, if which is dropping to exceed, alarm will occur.
T%	Set Value		Heating according to percent. The greater the number, the longer the heating time (20 sec as one cycle)

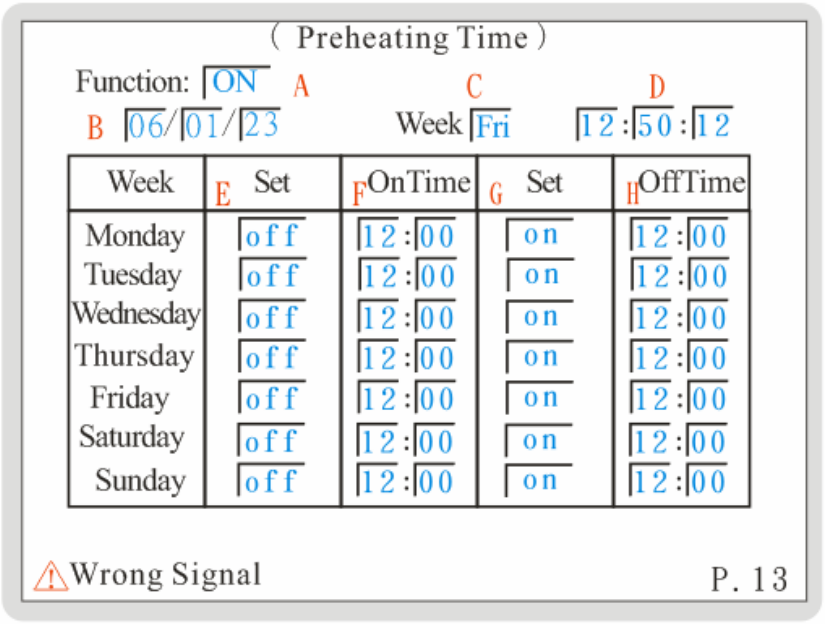
Notes:

If desiring to use the percent, Percent must be selected in the Temperature Setting of Engineer Screen. (Generally, is the repairers to use it, not the users to select)



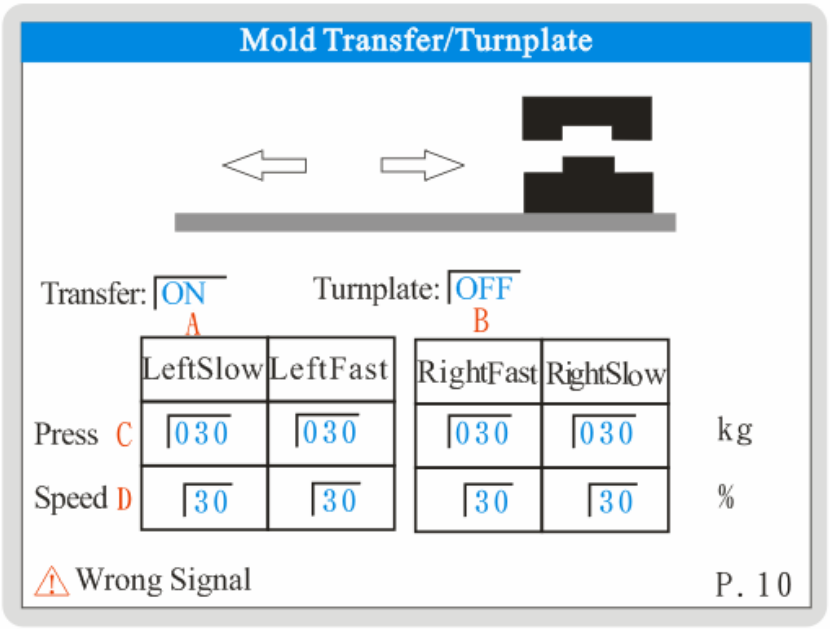
11-2. Preheating Time and Date Time Set

Press twice



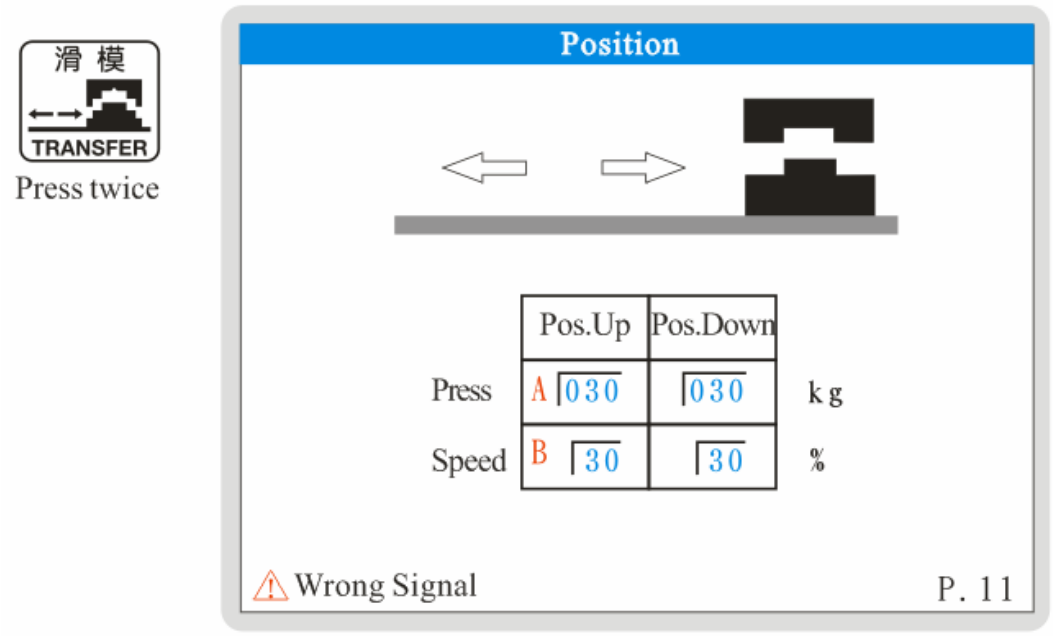
Code	Status	Scope	Description
A	Set Value	ON/OFF	Set the preheating function
B	Set Value	Date	Set Year/Month/Day
C	Set Value	Week	Set the week
D	Set Value	Time	Set the time for 24-hour
E	Set Value	ON/OFF	Set the function of auto power on
F	Set Value	Time	Set the time of auto power on
G	Set Value	ON/OFF	Set the function of auto power off
H	Set Value	Time	Set the time of auto power off

12. Mold Transfer Screen　　12-1. Mold Transfer/Turnplate Set



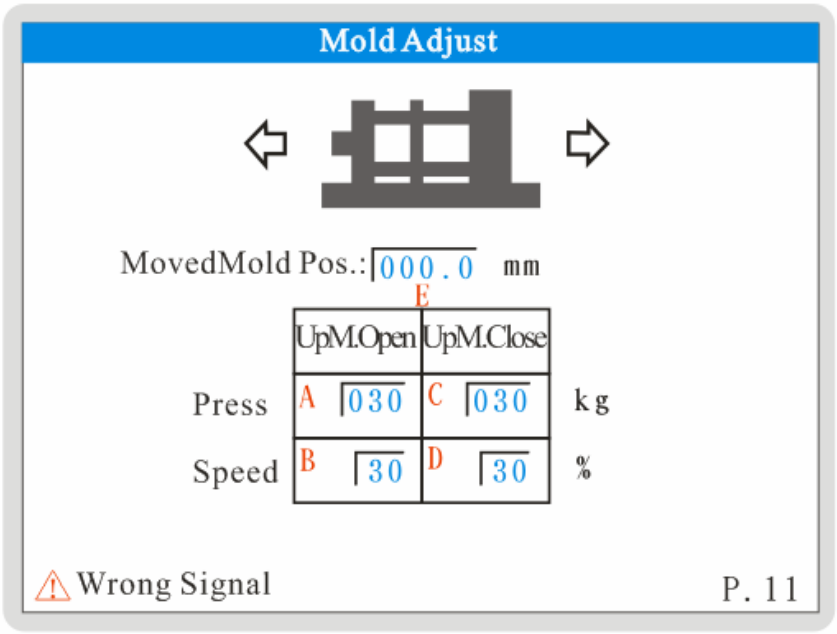
Code	Status	Scope	Description
A	Set Value	ON/OFF	Engineer function set 2 in Engineer Screen can only be switched by pressing SET button here when the single or double mold transfer is selected for the function of mold transfer.
B	Set Value	ON/OFF	Engineer function set 2 in Engineer Screen can only be switched by pressing SET button here when the single ON is selected for the function of turnplate.
C	Set Value	0-140 kg	The pressure of mold-transfer action when it is ON.
D	Set Value	0-99%	The flow of mold-transfer action when it is ON.

12-2. Position Set Page



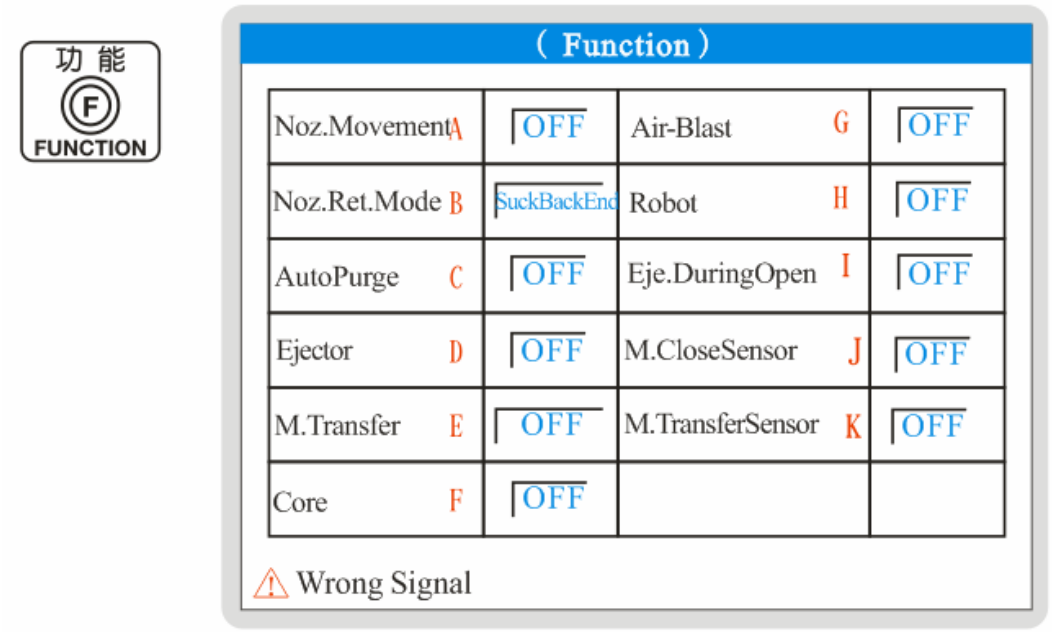
Code	Status	Scope	Description
A	Set Value	0-140 kg	The pressure of mold-transfer action when it is ON.
B	Set Value	0-99%	The flow of mold-transfer action when it is ON.

13. Mold Adjust Set



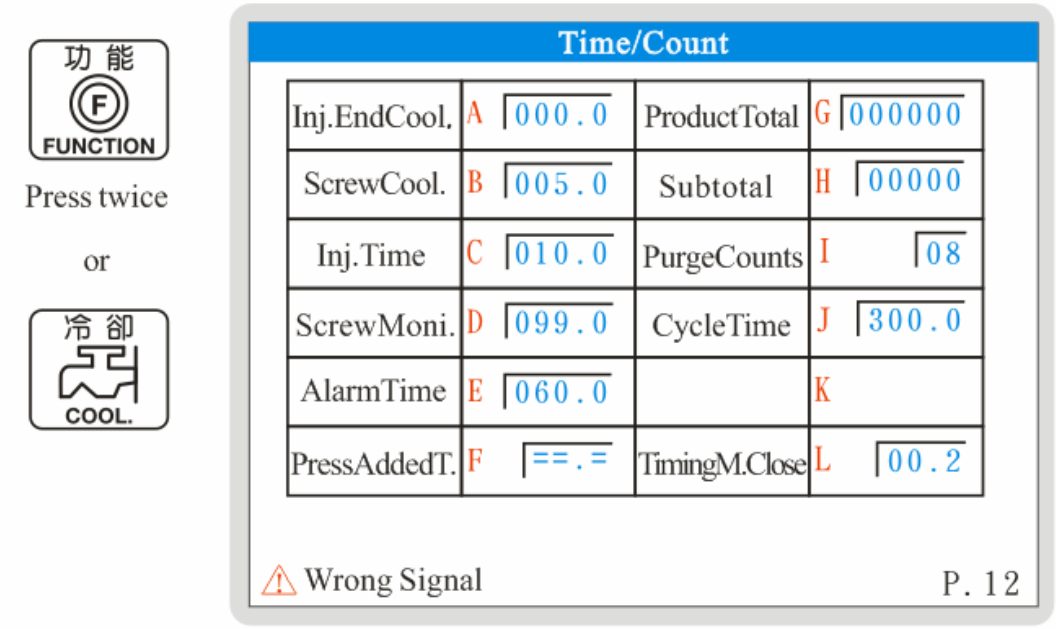
Code	Status	Scope	Description
A	Set Value	0-140 kg	The pressure of mold-open action when the mold-adjust is used.
B	Set Value	0-99%	The flow of mold-open action when the mold-adjust is used.
C	Set Value	0-140 kg	The pressure of mold-close action when the mold-adjust is used.
D	Set Value	0-99%	The flow of mold-close action when the mold-adjust is used.
E	Actual Value	0-999.9 mm	Display current position of moved mold.

14. Function Screen　　14-1. Function Set Page



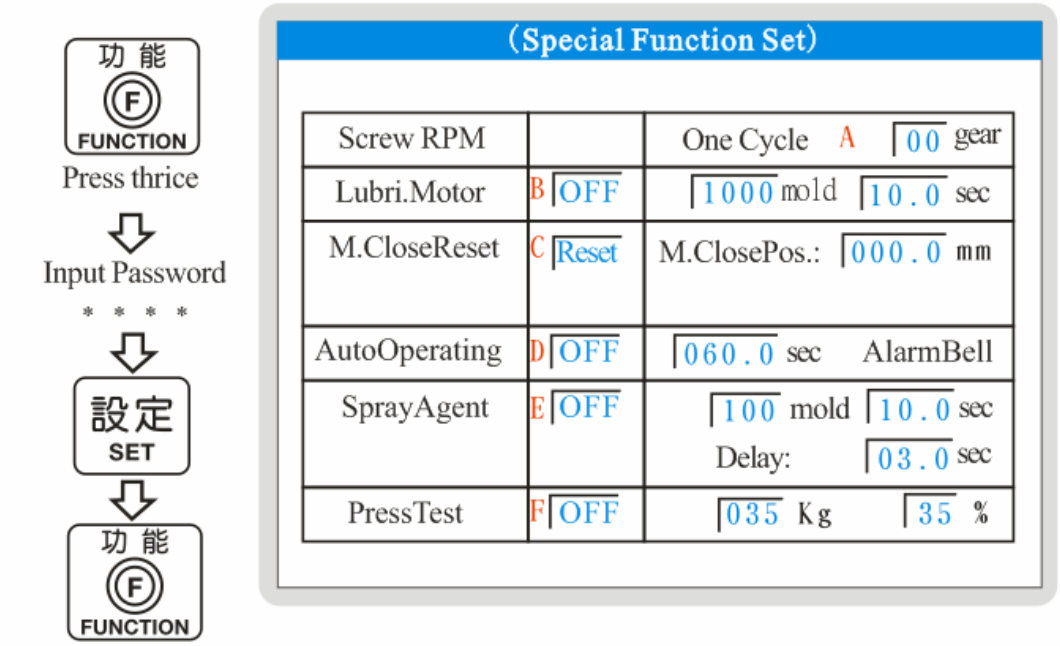
Code	Status	Scope	Description
A	Set Value	ON/OFF	The nozzle can act after injection end when ON.
B	Set Value	Cooling End Suck-Back End	Auto nozzle ret. will act after cooling end when it is selected (The nozzle movement must be selected ON); Auto nozzle ret. will act after suck-back end when it is selected.
C	Set Value	ON/OFF	Auto purge will act by injection when ON.
D	Set Value	ON/OFF	Ejector will act when ON.
E	Set Value	OFF/Transfer Left/Transfer Right	Engineer function set 2 in Engineer Screen can only be switched by pressing SET button here when the single or double mold transfer is selected for the function of mold transfer.
F	Set Value	ON/OFF	Core A will act when ON.
G	Set Value	ON/OFF	Air-Blast can act when ON.
H	Set Value	ON/OFF	Robot can act when ON.
I	Set Value	ON/OFF	Ejector During Mold-Open is allowed when ON.
J	Set Value	ON/OFF	Photocell sensor will perform to avoid foreign body in the mold close stroke when ON.
K	Set Value	ON/OFF	Photocell sensor will perform to avoid foreign body in the mold transfer stroke when ON.

14-2. Time / Count Page



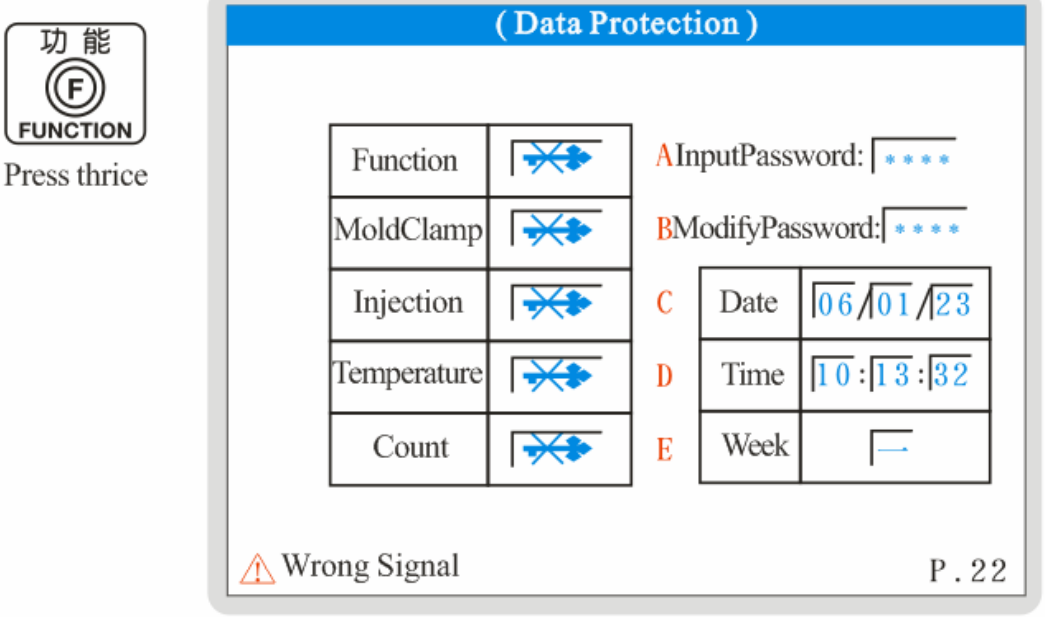
Code	Status	Scope	Description
A	Set Value	0-999.9 sec	Suck-Back and Screw will act after the set cooling time is performed when injection end.
B	Set Value	0-999.9 sec	The set cooling time will perform after screw end.
C	Set Value	0-999.9 sec	The same as the monitoring time of injection screen. When Position is selected for injection mode, holding will perform if the accumulative time of injection is equal to the injection time or monitoring time.
D	Set Value	0-999.9 sec	Display no stuff while the accumulative screw time is beyond this set one.
E	Set Value	0-999.9 sec	The accumulative alarm time will appear when the machine fails.
F	Set Value	0-99.9 sec	Time of increasing pressure will continue to perform after the hi-pressure position reaches, then close the hi-pressure.
G	Set Value	0-999999 molds	The alarm “Production Doesn’t Go On” will appear while the set counts of total production molds are produced.
H	Set Value	0-99999 molds	The alarm “Continue To Produce Again” will appear while reaching the subtotal counts of production molds are produced.
I	Set Value	0-99 counts	Set the times of purge.
J	Set Value	0-999.9 sec	The alarm occurs if accumulative time of cycle monitoring is beyond this set value.
K			
L	Set Value	0-9.9 sec	Closing mold while delaying this set time between after the previous 1 mold and before the next one.

14-4. Special Function Set Screen



Code	Status	Scope	Description
A	Set Value	0-99 gears	As the RPM parameter
B	Set Value	ON/OFF	When ON, the seconds that lubricating motor is started up after the molds are set.
C	Set Value	Reset	
D	Set Value	ON/OFF	When ON, the action seconds of alarm bell for auto operating can be set.
E	Set Value	ON/OFF	When ON, the action seconds after delay seconds that in what molds can be set.
F	Set Value	ON/OFF	When ON, the pressure can be tested according to the set pressure/flow.

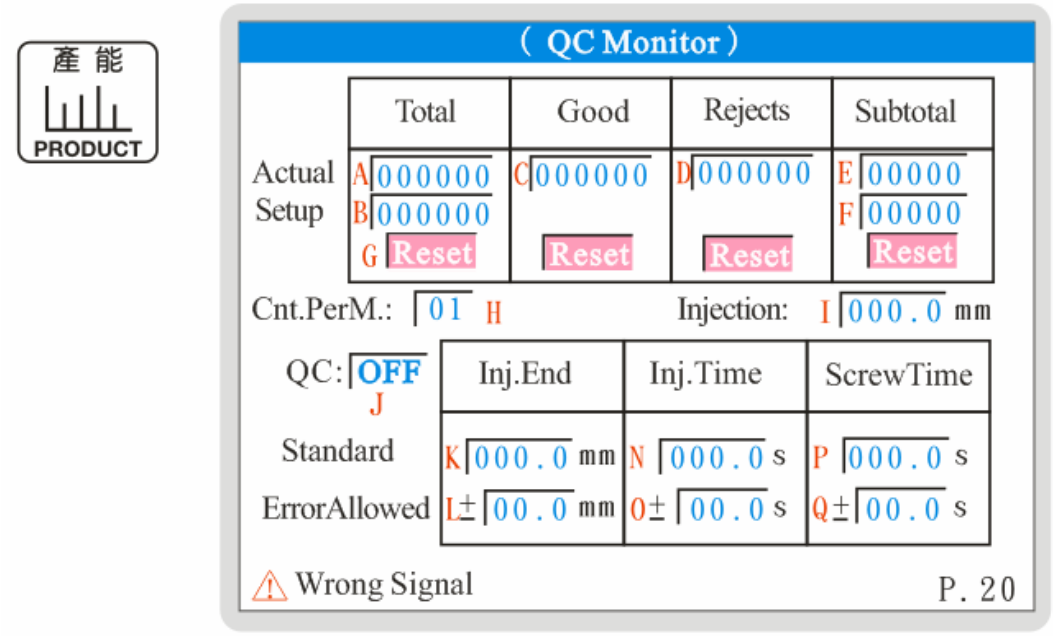
14-3. Data Protection Set



Code	Status	Scope	Description
A	Set Value		The settings of function screen is disabled to change if isn't selected.
B	Set Value		The set value of mold clamp is disabled to change if isn't selected.
C	Set Value		The injection conditions will be disabled to change if isn't selected.
D	Set Value		The setup temperature of cylinder will be disabled to chang if isn't selected.
E	Set Value		The counting data will be disabled to change if isn' selected.

Remarks: The correct password must be inputted to change the status of this page.

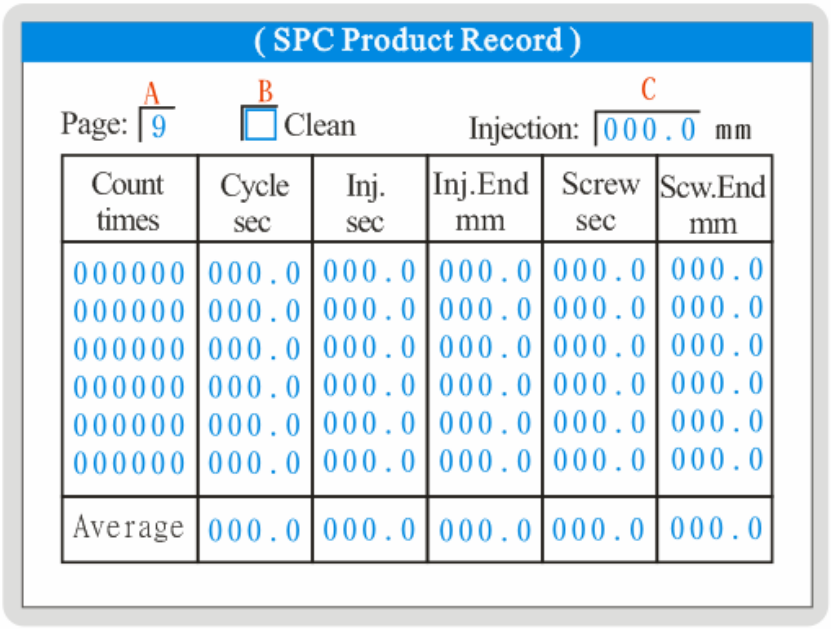
15. Production Screen　　15-1. QC Monitoring Set Page



Code	Status	Scope	Description
A	Actual Value	0-999999	Display current production.
B	Set Value	0-999999	Quantity desired to produce.
C	Actual Value	0-999999	Display the good products produced at present.
D	Actual Value	0-999999	Display the rejects produced at present.
E	Actual Value	0-99999	Display the subtotal production at present.
F	Set Value	0-99999	Alarm for several seconds once the subtotal quantity is reached, and continue to act the next mold after alarm ends.
G	Set Value	By Setting	Move the reverse white to the place of Reset, then the actual value will reset by pressing SET button.
H	Set Value	0-99	The amount of product that can be produced at one mould.
I	Actual Value	0-999.9 mm	Display the present position of screw pole.
J	Set Value	ON/OFF	Monitor according to the set error value of K±L, N±O and P±Q when ON.
K	Show Value	0-999.9 mm	Display the standard value of injection end at present.
L	Set Value	0-99.9 mm	One error of injection end allowed.

15-2. Product Record Page

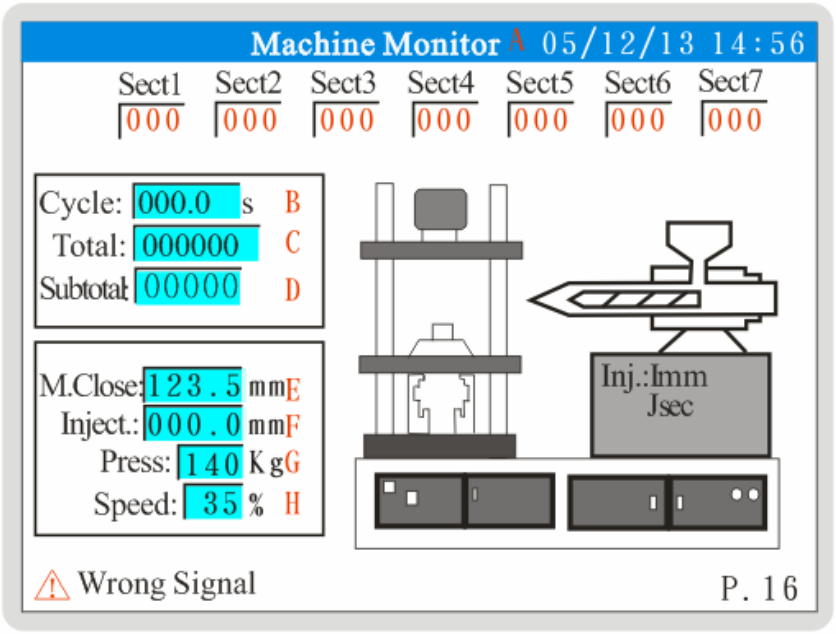
Press twice



Code	Status	Scope	Description
A	Set Value	0-9	Press Numeral button then Set button to switch the screens.
B	Set Value		Clean the record contents by press SET button.
C	Actual Value	0-999.9 mm	Display the current position of injection.

16. Monitoring Screen

16-1. Machine Monitoring Page



Code	Status	Scope	Description
A	Actual Value	Date	Display Year, Month and Day at present.
B	Actual Value	0-999.9 sec	Display the time per mold at present.
C	Actual Value	0-999999	Display the current total products.
D	Actual Value	0-99999	Display the current subtotal products.
E	Actual Value	0-999.9 mm	Display the present position of mold close.
F	Actual Value	0-999.9 mm	Display the present position of injection.
G	Actual Value	0-140 kg	Display the current pressure.
H	Actual Value	0-99%	Display the current flow.
I	Actual Value	0-99.9 rpm	Display the current RPM of screw pole.
J	Actual Value	0-399 C	Display the current temperature of each section.

16-2. Input-Port Monitoring

Press twice

(Input-Port Monitor)

LeftEje.Adv.End	0	NozzleAdv.End	12
LeftEje.Ret.End	1	NozzleRet.End	13
Right/MidEje.Adv.End	2	AutoStartup---Right	14
Right/MidEje.Ret.End	3	Photocell	15
M.CloseAllowed	4	M.S.End	16
Min.MoldThickness	5	HeaterStartedEnd	17
AutoStartup---Left	6	LeftTransferSlow	18
ElectricStopKey	7	TransferLeftEnd	19
RobotEnd	8	RightTransferSlow	20
FrontSafeDoor	9	TransferRightEnd	21
SideSafeDoor	10	Pos.Up/AirDoorOpenEnd	22
PressAddedEnd	11	Pos.Dn/AirDoorProtected	23
		Screw RPM	24

⚠Wrong Signal

P. 17

※ "*" will appear before the input number when there is input signal in the input port.

16-3. Output-Port Monitoring

Output-Port Monitor

Press thrice

NozzleAdv.Valve	40	Right/MidEje.Adv.	56
NozzleRet.Valve	41	Right/MidEje.Ret.	57
Inj.OilValve	42	AlarmBell	58
InjectionValve	43	DifferentialValve/SmallPress	59
Suck-BackValve	44	Pos.Up/AirDoorOpen	60
ScrewValve	45	Pos.Dn/AirDoorClose	61
Hi-PressureValve	46	NozzleUp	62
LeadValve	47	NozzleDown	63
MoldCloseValve	48	M.CloseSafeValve	64
MoldOpenValve	49	SmallEjectorPump	65
M.OpenOil-Pressure	50	AirAbsorbed	66
LeftEje.Adv.	51	MoldOpenEnd	67
LeftEje.Ret.	52	FixedMoldAir-Blast	68
TransferLeft	53	MovedMoldAir-Blast	69
TransferRight	54	MotorStarted	70
MoldTransferSlow	55	HeaterStartup	71

※ "*" will appear before the output number when there is output signal in the output port.

16-4. I/O Expansion

Press four times

(I/O Expansion Monitor)

Check Core A In	25	Core A In Valve	73
Check Core A Out	26	Core A Out Valve	74
Check Core B In	27	Core B In Valve	75
Check Core B Out	28	Core B Out Valve	76
	29		77
	30		78
	31		79
	32		80

⚠ Wrong Signal P . 17

※ "*" will appear before the input number when there is input signal in the input port.

※ "*" will appear before the output number when there is output signal in the output port.

16-5. Pointing Monitoring

Press four times

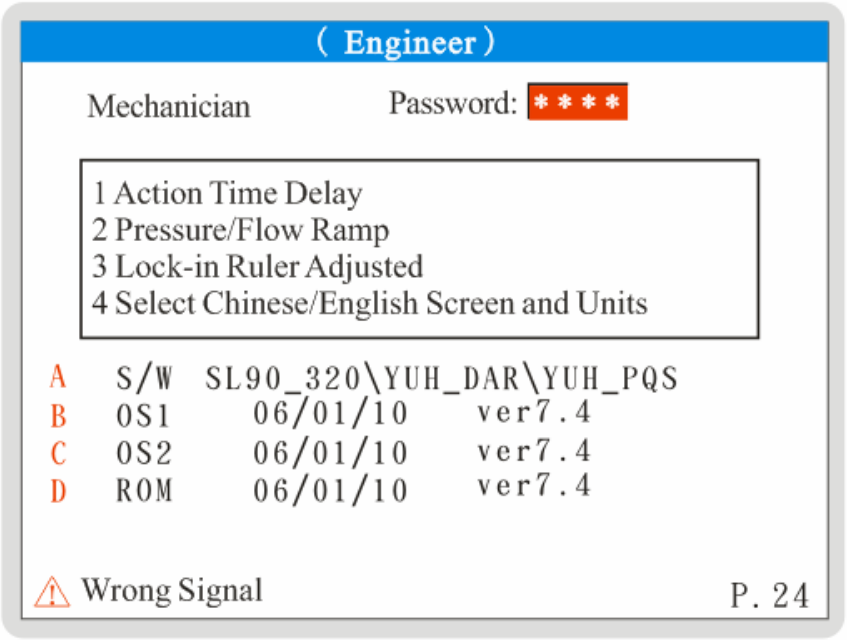
(Pointing Monitor)

⌈100	⌈200	⌈300	⌈400	⌈500
101	201	301	401	501
102	202	302	402	502
103	203	303	403	503
104	204	304	404	504
105	205	305	405	505
106	206	306	406	506
107	207	307	407	507
108	208	308	408	508
109	209	309	409	509

⚠ Wrong Signal P . 19

※ "*" will appear before the number when there is signal in the position of pointing.

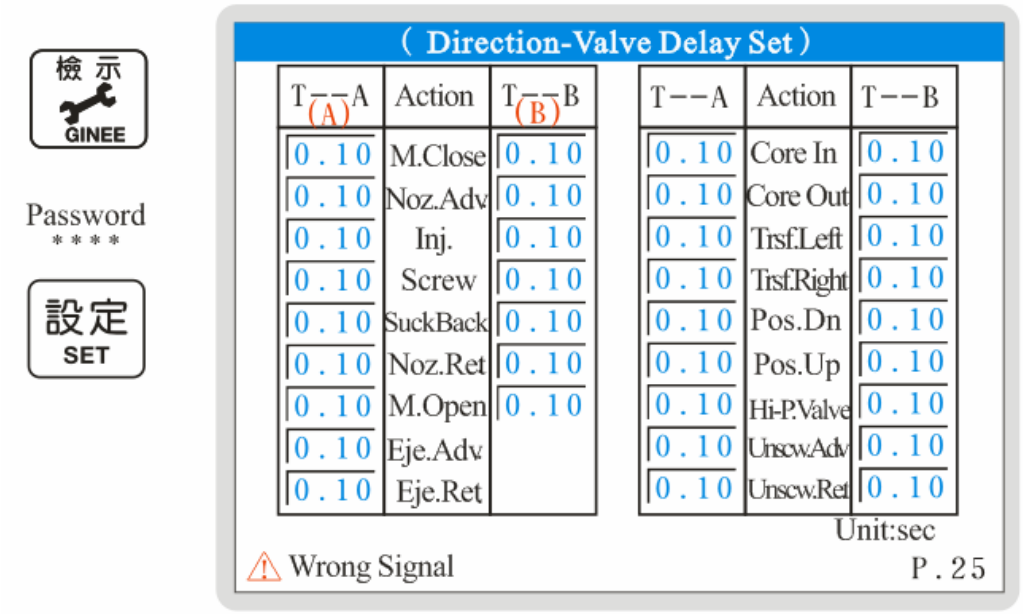
17. Engineer Screen　　17-1. Engineer Page



※ Input password to enter.

Code	Status	Scope	Description
A	Display		Procedure name
B	Display		OS1 is the date and version.
C	Display		OS2 is the date and version.
D	Display		ROM is the date and version.
	Display		

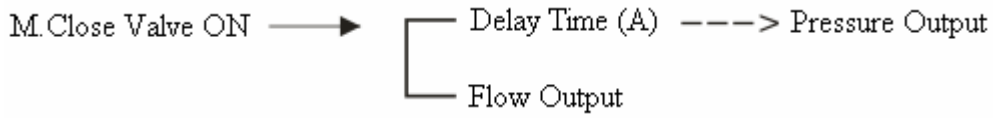
17-2. Direction-Valve Delay Set Page



Code	Status	Scope	Description
A	Set Value	0-2.31 sec	Set the delay of direction valve ON.
B	Set Value	0-2.31 sec	Set the delay of direction valve OFF.

Description:

E.g.: Mold-Close Action Stroke:

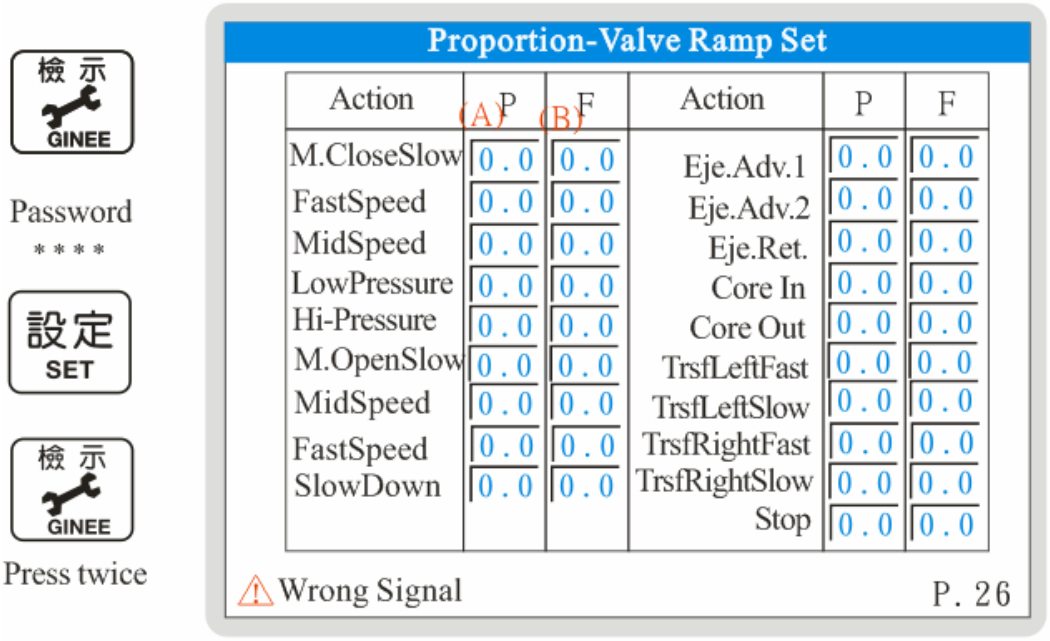


T--B: The delay time (B) is before direction valve closed and after pressure closed, then close the direction valve.

E.g.: The Stop Stroke of Mold-Close Action

(Generally, please set to 0.00 sec)

17-3. Proportion-Valve Ramp Set Page-1



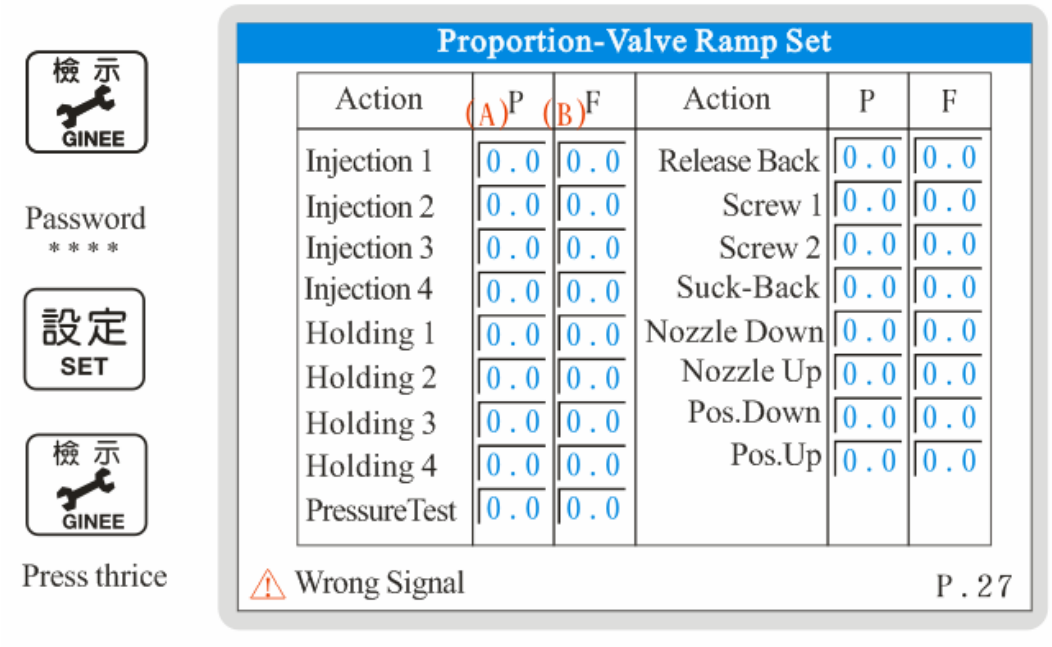
Code	Status	Scope	Description
A	Set Value	0-6.3	Set the action pressure started up to the speed of set value.
B	Set Value	0-6.3	Set the action flow started up to the speed of set value.

Description:

(A) Column is to set the pressure up ramp, the unit is 0.1 sec. The pressure is up to the set value in this time.

(B) Column is to set the flow up ramp, the unit is 0.1 sec. The flow is up to the set value in this time.

17-4. Proportion-Valve Ramp Set Page-2


檢 示
GINEE
Password
* * * *
設定
SET
檢 示
GINEE
Press thrice
Proportion-Valve Ramp Set
Action (A)P (B)F Action P F
Injection 1 0.0 0.0 Release Back 0.0 0.0
Injection 2 0.0 0.0 Screw 1 0.0 0.0
Injection 3 0.0 0.0 Screw 2 0.0 0.0
Injection 4 0.0 0.0 Suck-Back 0.0 0.0
Holding 1 0.0 0.0 Nozzle Down 0.0 0.0
Holding 2 0.0 0.0 Nozzle Up 0.0 0.0
Holding 3 0.0 0.0 Pos.Down 0.0 0.0
Holding 4 0.0 0.0 Pos.Up 0.0 0.0
PressureTest 0.0 0.0
Wrong Signal
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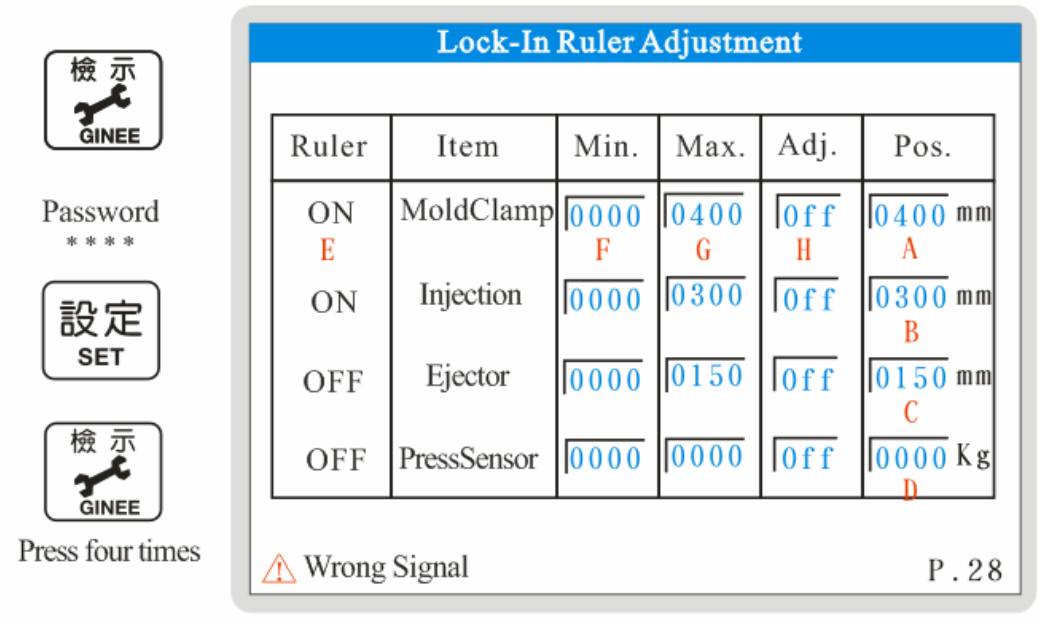
Code	Status	Scope	Description
A	Set Value	0-6.3	Set the action pressure started up to the speed of set value.
B	Set Value	0-6.3	Set the action flow started up to the speed of set value.

Description:

(C) Column is to set the pressure up ramp, the unit is 0.1 sec. The pressure is up to the set value in this time.

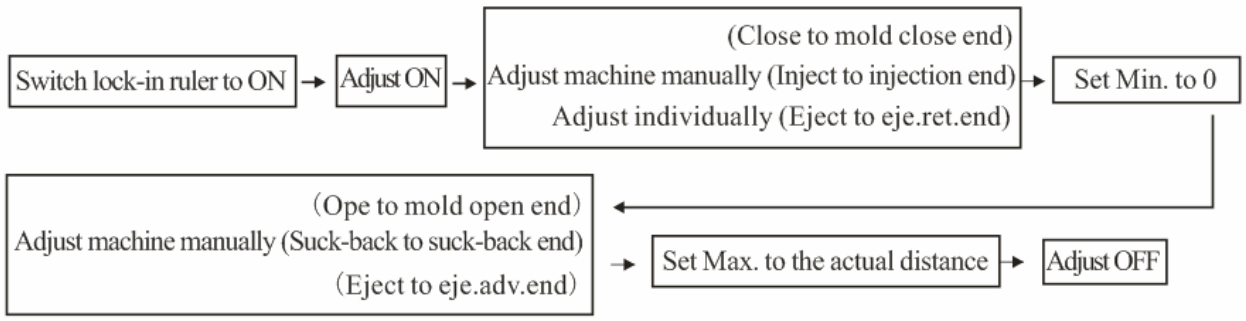
(D) Column is to set the flow up ramp, the unit is 0.1 sec. The flow is up to the set value in this time.

17-5. Lock-In Adjust Page

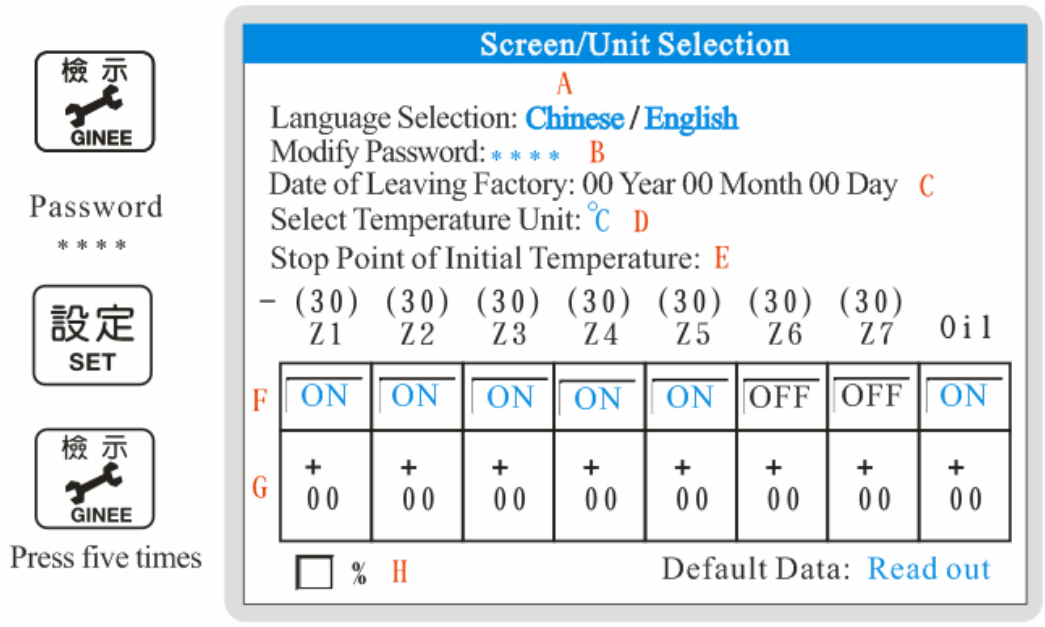


Code	Status	Scope	Description
A	Actual Value	0-999.9 mm	Display the current position of mold-open ruler.
B	Actual Value	0-999.9 mm	Display the current position of injection ruler.
C	Actual Value	0-999.9 mm	Display the current position of ejector ruler.
D	Actual Value	0-999.9 kg	Display the current pressure of sensor.
E	Set Value	ON/OFF	Set the lock-in ruler to ON or OFF.
F	Set Value	0	The place that the minimum of lock-in ruler is set.
G	Set Value		The place that the maximum of lock-in ruler is set.
H	Set Value	ON/OFF	Select ON/OFF to adjust or no adjust the lock-in ruler.

The steps to adjust the lock-in ruler:

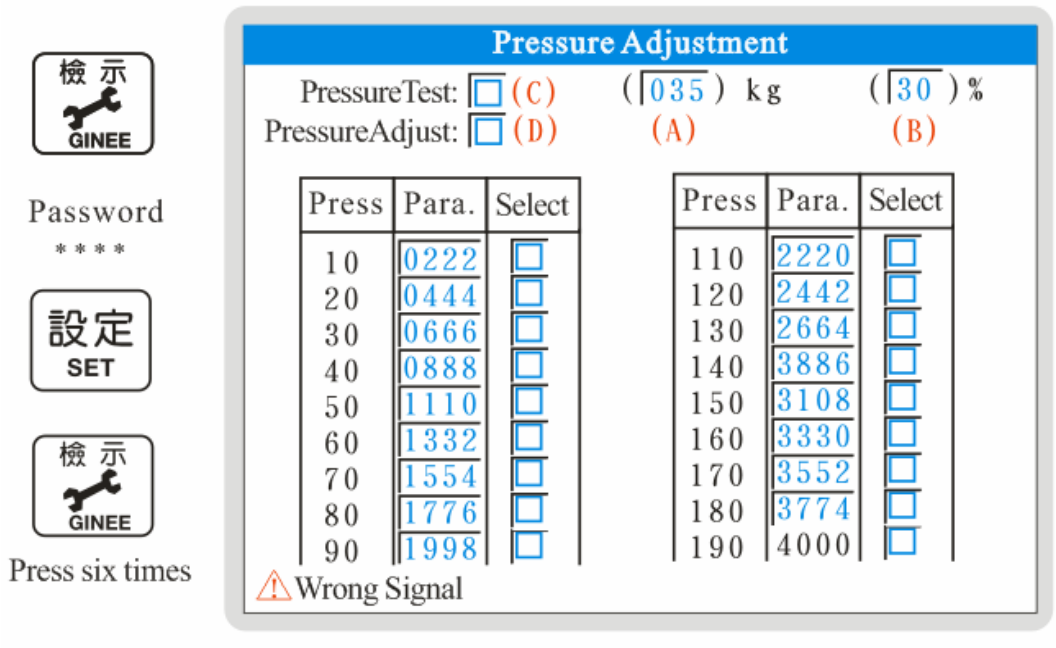

Switch lock-in ruler to ON
Adjust ON
(Close to mold close end)
Adjust machine manually (Inject to injection end)
Adjust individually (Eject to eje.ret.end)
Set Min. to 0
(Ope to mold open end)
Adjust machine manually (Suck-back to suck-back end)
(Eject to eje.adv.end)
Set Max. to the actual distance
Adjust OFF

17-6. Screen/Unit Selection


檢示
GINEE
Password
* * * *
設定
SET
檢示
GINEE
Press five times
Screen/Unit Selection
A
Language Selection: Chinese / English
Modify Password: * * * * B
Date of Leaving Factory: 00 Year 00 Month 00 Day C
Select Temperature Unit: °C D
Stop Point of Initial Temperature: E
- (30) (30) (30) (30) (30) (30) (30)
Z1 Z2 Z3 Z4 Z5 Z6 Z7 Oil
F ON ON ON ON ON OFF OFF ON
G + 00 + 00 + 00 + 00 + 00 + 00 + 00 + 00
% H
Default Data: Read out

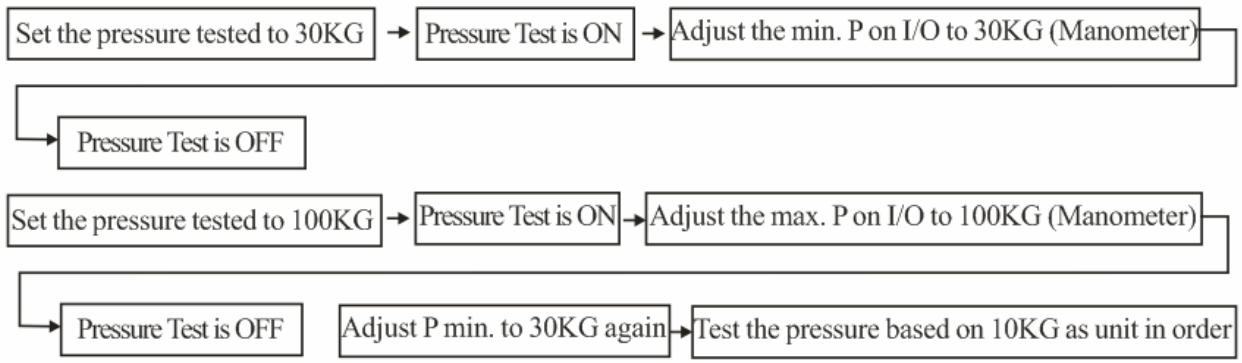
Code	Status	Scope	Description
A	Actual Value	Chinese/English	Press SET button to switch the language display.
B	Set Value	0-9999	Modify the password entering to the Engineer Screen.
C	Set Value		Input the date of machine leaving factory to be convenient to view.
D	Set Value	C/F	Switch the temperature unit.
E	Set Value	5-40	Avoid the temperature overheated, and act PID heating when there still are (D) degrees before reaching the set value of temperature.
F	Set Value	ON/OFF	Set the sections used by temperature.
G	Set Value	±0~99	Correct the temperature of each section; if temperature 147 is shown on the computer and 150 is measured actually, +3 will be corrected.
H	Default Value	ON/OFF	Set temperature of the first section to use Percent output, or use temperature control.
	Default Value	Readjustment	The initial data in the computer is default; please don't read out at will, otherwise, the data of machine need to be readjusted, such as, temperature used sections, resistance ruler range and so on.

17-7. Pressure Adjustment

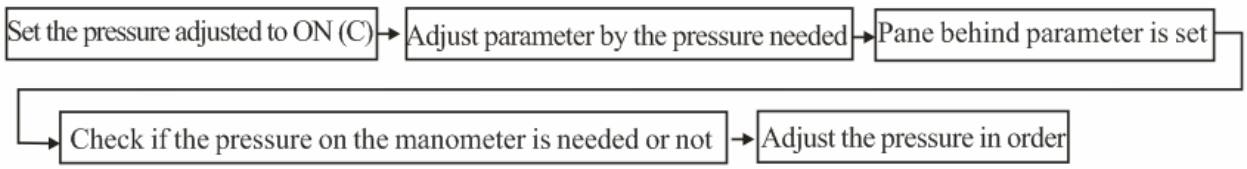


Code	Status	Scope	Description
A	Set Value	0-140 kg	Pressure value for pressure test in using.
B	Set Value	0-99%	Flow value for pressure test in using.
C	Set Value	Choose √	Test according to the setting pressure output when using.
D	Set Value	Choose √	Please first tick here when parameter adjusted fine is desired to use.

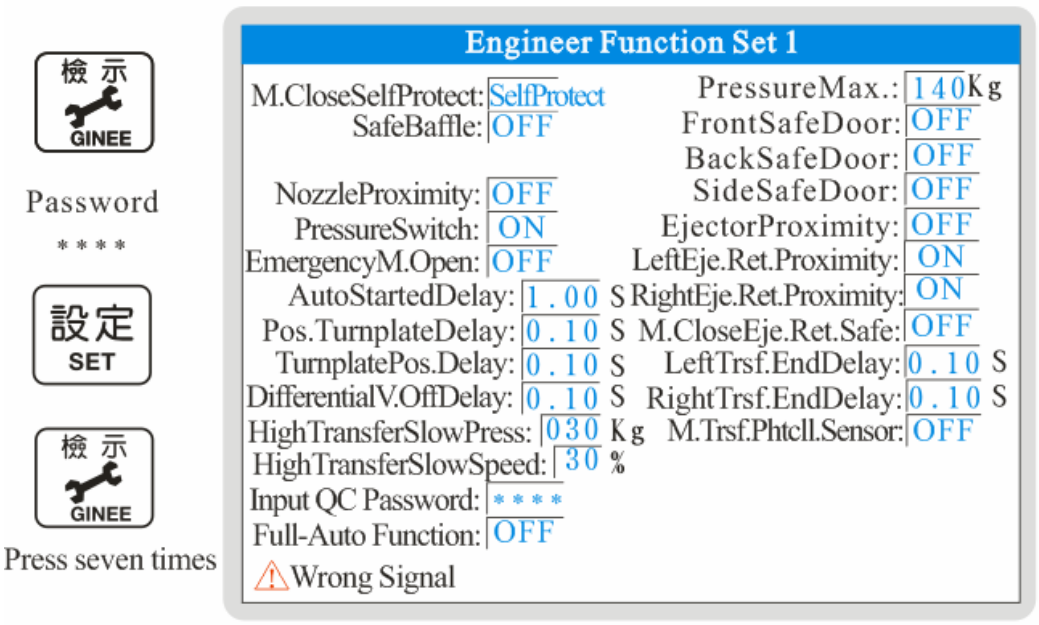
Pressure Test Steps:


Set the pressure tested to 30KG
Pressure Test is ON
Adjust the min. P on I/O to 30KG (Manometer)
Pressure Test is OFF
Set the pressure tested to 100KG
Pressure Test is ON
Adjust the max. P on I/O to 100KG (Manometer)
Pressure Test is OFF
Adjust P min. to 30KG again
Test the pressure based on 10KG as unit in order

Adjust the pressure according to the following steps if there is still a little error after test:

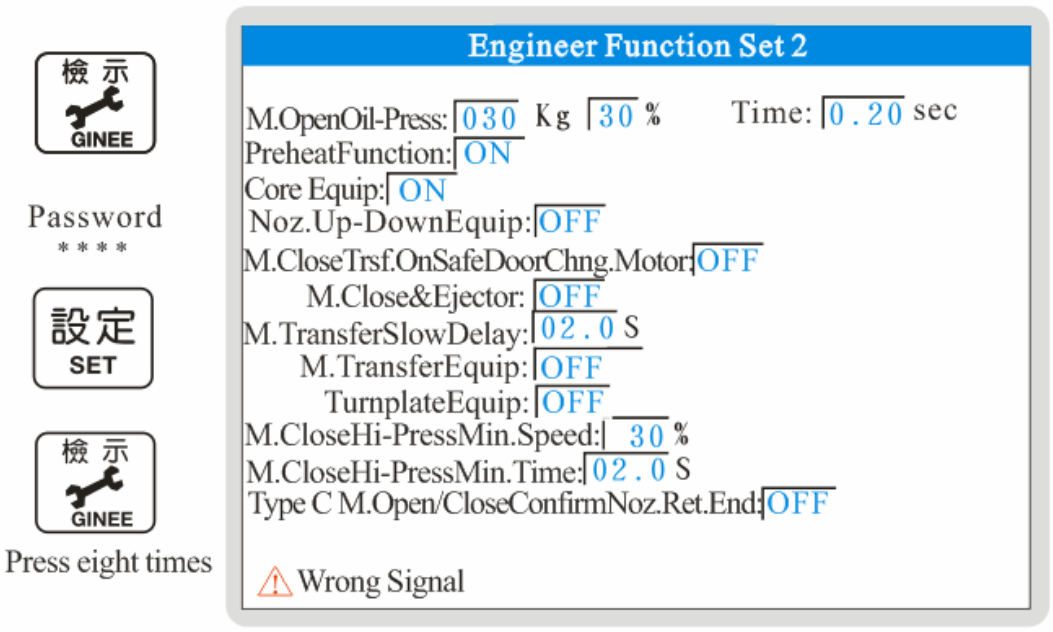

Set the pressure adjusted to ON (C)
Adjust parameter by the pressure needed
Pane behind parameter is set
Check if the pressure on the manometer is needed or not
Adjust the pressure in order

17-8. Engineer Function Set 1



※ Press SET button to switch options in the screen of engineer function set.
The function is not opened for this page if the option contents are disabled to switch on the data setting.

17-9. Engineer Function Set 2



※ Press SET button to switch options in the screen of engineer function set.
The function is not opened for this page if the option contents are disabled to switch on the data setting.